



CEWELD Alloy 825

TYPE	Solid Nickel based welding wire for gas shielded arc welding									
APPLICATIONS	The excellent corrosion-resistant properties of CEWELD Alloy 825 make the alloy a suitable choice for a variety of difficult applications. Uses include fabricated equipment found in chemical and petro- chemical processing, pulp and paper manufacturing, flue gas desulphurization systems and metal pickling operations.									
PROPERTIES	Excelent weldability with fully austenitic weld metal with high resistance against stress corrosion cracking and pitting in media containing chloride ions. Good corrosion resistance against reducing acids due to the combination of Ni, Mo and Cu. Sufficient resistance against oxidizing acids. The weld metal is corrosion resistant in sea water. Good resistance to nitric acid.									
CLASSIFICATION	AWS	A 5.14: ERNiFeCr-1								
	EN ISO	18274: S Ni 8065(NiFe30Cr21Mo3)								
	W.Nr.	2.4858								
	F-nr	43								
	FM	6								
SUITABLE FOR	G-X7NiCrMoCuNb25-20, X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-5, NiCr21Mo, X1NiCrMoCu31-27-4, N08926, N08904, N08028, N08825 ALLOY 825 1.4500, 1.4529, 1.4539 (904L), 2.4858, 1.4563, 1.4465, 1.4577 (310Mo), 1.4133, 1.4500, 1.4503, 1.4505, 1.4506, 1.4531, 1.4536, 1.4585, 1.4586									
APPROVALS										
WELDING POSITIONS	    									
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu	Al
	0.05	0.3	0.8	22	42	3	1	30	2	0.1
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness		
					-196°C					
	As Welded	425	630	30	70			HRc		
REDRYING	Not required									
GAS ACC. EN ISO 14175	I1									



CEWELD Alloy 825

ALLOY 825 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663419064
BS-300	13,6	8720663419606