



# 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.                                                                                                                                                                             |                                 |                         |           |                         |    |    |          |    |     |
| PROPRIÉTÉS                                           | 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.                                                                                                                                                  |                                 |                         |           |                         |    |    |          |    |     |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A 5.14: ERNiFeCr-1              |                         |           |                         |    |    |          |    |     |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 18274: S Ni 8065(NiFe30Cr21Mo3) |                         |           |                         |    |    |          |    |     |
|                                                      | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 2.4858                          |                         |           |                         |    |    |          |    |     |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 43                              |                         |           |                         |    |    |          |    |     |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 6                               |                         |           |                         |    |    |          |    |     |
| CONVIENT POUR                                        | G-X7NiCrMoCuNb25-20, X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-5, NiCr21Mo, X1NiCrMoCu31-27-4,<br>N08926, N08904, N08028, N08825 ALLOY 825<br>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                                                                                                                                                                                                                    |                                 |                         |           |                         |    |    |          |    |     |
| AGRÉMENTS                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                 |                         |           |                         |    |    |          |    |     |
| POSITIONS DE SOUDAGE                                 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PF</div> |                                 |                         |           |                         |    |    |          |    |     |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Si                              | Mn                      | Cr        | Ni                      | Mo | Ti | Fe       | Cu | Al  |
|                                                      | 0.05                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 0.3                             | 0.8                     | 22        | 42                      | 3  | 1  | 30       | 2  | 0.1 |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | R <sub>P0,2</sub><br>(MPa)      | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V |    |    | Hardness |    |     |
|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                 |                         |           | -196°C                  |    |    |          |    |     |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 425                             | 630                     | 30        | 70                      |    |    | HRc      |    |     |
| ETUVAGE                                              | 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 |