

Strip Electrode for Electroslag Overlay Welding

BA-STRIP 625

Classification: EN ISO 18274:
SFA-5.14:

B Ni 6625
EQNiCrMo-3

Main Application:

BA-STRIP 625 is a strip electrode for electroslag overlay welding (ESW). Used to obtain a Nickel-Chromium-Molybdenum corrosion resistant overlay on mild steel and low alloy steels. The overlay has excellent resistance to stress corrosion cracking (SCC) in chlorides and excellent resistance to pitting and intergranular corrosion.

Typical analysis and chemical composition acc. to EN ISO 18274 and AWS A5.14: (Weight Percent)

Strip electrode	Ni	Si	C	Cr	Mn	Ti	Fe	Nb	Al	Mo	S	P	Cu total	Others
Typical analysis BA-STRIP 625	Bal.	0.2	0.02	22.0	0.2	0.1	0.8	3.5	0.1	9.0	0.009	0.014	0.2	< 0.50
B Ni 6625 acc. to ISO 18274	≥ 58.0	0.5	0.1	20.0 – 23.0	0.5	0.4	5.0	3.0 – 4.2	0.4	8.0 – 10.0	0.015	0.020	0.5	0.5
EQNiCrMo-3 acc. to AWS A5.14	≥ 58.0	0.50	0.10	20.0 – 23.0	0.50	0.40	5.0	Nb+Ta 3.15 – 4.15	0.40	8.0 – 10.0	0.015	0.020	0.50	0.50

Base Materials:

Mild steels and low alloy steels.

Suitable flux: BF 46

Flux type suitability is strongly dependent on its application. In combination with the strip electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package Forms:

Coils or wound spools as standard package forms for strip electrodes.

Dimensions:

30 x 0.5 mm, 60 x 0.5 mm; sizes and tolerances acc. to ISO 544 and AWS A5.14.
Other dimensions on request.

Strip Electrode Surface:

Smooth finish free from surface defects and foreign matter.