



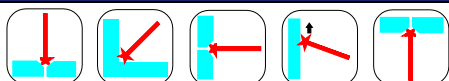
# 825

AWS A 5.14: ER NiFeCr-1 ISO 18274: S-Ni 8065(NiFe30Cr21Mo3)  
W.N 2.4858

## DESCRIPTION

Nickel alloyed welding wire for welding Inconel 825 and alloys of similar composition and for cladding of carbon steels and low alloyed steels. Excellent corrosion resistant particularly in reducing chemicals such as sulphuric and phosphoric acids makes it useful in chemical and petro-chemical processing but also used in paper manufacturing processes and for power plants.

### WELDING POSITIONS



### CURRENT

Tig DC-  
Mig DC+

### SHIELDING GAS

Tig: I1, I3  
Mig: I1, I3, M12

## BASE MATERIALS

G-X7NiCrMoCuNb25-20, X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-5, NiCr21Mo, X1NiCrMoCu31-27-4, N08926, N08904, ALLOY 825, N08028, UNS N08825 W.Nr: 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

## MECHANICAL PROPERTIES

<i>R<sub>m</sub></i> (Mpa)	<i>R<sub>p 0,2</sub></i> (Mpa)	<i>A5</i> (%)	<i>KV(J)</i>
640	430	30	

## CHEMICAL ANALYSIS(%)

C	Mn	Si	Ni	Cr	Ti	Cu	Mo	Fe	Al
<0,05	0,8	<0,5	43	22	1,0	2,0	3,0	30	<0,2

## PACKAGING

<b>Dimension Tig (mm)</b>	1,6	2,0	2,4	3,2
<b>Box (kg)</b>	5	5	5	5
<b>Dimension Mig (mm)</b>	1,0	1,2		
	15	15		