

VBC Alloy 0237 Inco 625

Designation and Description	MC-TEC GRADE GTAW Solid Welding Wire Nickel Base	Issued: Mar/14	MSRR: 9500/237	AMS: 5837G
		Revision: 01		
Cross Reference/ Conformance Specification	MSRR 9500/237 AMS 5837G BS EN ISO 18274:2010 NiCr22Mo9Nb/Ni 6625 BS2901-5:1990 NA43	AWS A5.14/5.14M:2005 ERNiCrMo-3 DIN 1736:1985 2.4831 UNS Number N06625 JIS YNiCrMo-3		
Metallurgical Background Information	IN 625 is produced by special lubricant free, roller-die forming surface abrasion and cleaning processes. This manufacturing route ensures consistent metallurgical integrity of the alloy and surface physical purity of the welding wire is maintained. IN 625 is a single phase Ni-Cr-Mo high temperature alloy.			
Materials To Be Welded, Applications and Advice	IN 625 is used principally for gas shielded arc welding of INCONEL 625, 601 and similar materials. Frequently used in dissimilar metal welding applications for complex Superalloy welds. MSRR 7080, 7101, 7150; MAR-M002 (Hole sealing only) SAE-AMS 5666, 5879, 5599, 5581 BS 3072, 3074, 3076 Pure argon required for GTAW			
Wire Chemistry WT% (as per AMS)	Carbon – 0.10% max		Molybdenum – 8.0-10.0%	
	Manganese – 0.50% max		Niobium – 3.15-4.15%	
	Silicon – 0.50%max		Cobalt – 1.0% max	
	Phosphorous – 0.015% max		Titanium – 0.40% max	
	Sulphur – 0.015% max		Aluminium – 0.40% max	
	Chromium – 20.0-23.0%		Iron – 5.0% max	
			Nickel – Balance	
Weld Properties	Hardness 160/220 VN		Density 8.44 gm/cc	
Sizes and Forms of Supply	Straight Length: 2.5 kg Packs 36" / 914mm lengths Flag tagged 0.8 – 3.2mm diameter		Spooled Wire: Precision layer wound with controlled cast and helix 300mm diameter standard 0.8 – 1.6mm spool	

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