## Standards:

| | |
|---|---|
| EN ISO 14172 | E Ni 6625 (NiCr22Mo9Nb) |
| EN 14700: | E Ni 2 |
| AWS A 5.11: | E NiCrMo 3 |
| Mat.-No.: | 2.4621 |

# capilla® 625 K

## Product description:

High corrosion resistance in several media, also against stress corrosion cracking.
Scale resistant at service temperatures up to 1100°C, good mechanical properties up to 1000°C and down to -196°C.

Max. service temperature in sulphurous media: 500°C.

## Applications:

Joints and claddings of similar materials and steels.

Fusion welding of CrNi(N) steels for cryogenic applications and heat treatable nickel steels.

Appropriate base metals:

Alloy 800, 1.4876, 2.4856, 1.4539.

## Typical weld metal composition:

[wt. - %]

| | C | Cr | Mo | Nb | Ni |
|---|---|---|---|---|---|
| **Min.** | | **19** | **8** | **2** | |
| **Max.** | **0,6** | **30** | **11** | **4** | **Bal.** |

## Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

| | | |
|---|---|---|
| Tensile strength $R_m$: | 760 | [MPa] |
| Yield strength $R_{p0,2}$: | 450 | [MPa] |
| Yield strength $R_{p1,0}$: | - | [MPa] |
| Elongation (L=5d): | 30 | [%] |
| Impact strength (ISO-V): | 75 | [J] |
| | 60 | [J] -196°C |

Positions: all except PG

Redrying: 320°C/2h

**Dimension:**

| Ø [mm] | Length [mm] | Welding current [A] |
|---|---|---|
| 2,5 | 300 | 60 – 90 |
| 3,25 | 350 | 80 – 110 |
| 4,0 | 350 | 100 – 150 |
| 5,0 | 350 | 150 – 200 |

**Polarity** =(+)

**also available:**
find in table of content

Capilla 625
Capilla 625 MIG

Capilla 625 WIG