

## Description and Application

**DW-N625** is a nickel based flux cored wire for welding nickel based alloys 625, 825 and also super austenitic stainless steels.

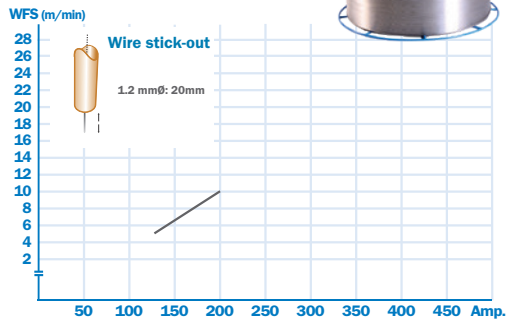
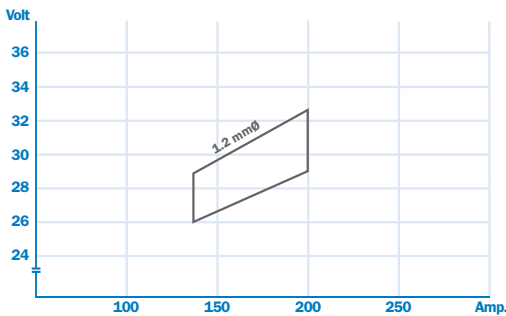
**DW-N625** has a stable arc with minimal spatter, which makes it also an excellent product for welding in all positions.

This wire is recommended for a wide variety of applications, including overlay welding of carbon steel or low alloy steels and a wide variety of dissimilar metal joints.

Please note that for circumferential joining of pipes in fixed positions, DW-N625P is a better choice than DW-N625.



### Recommended Parameter Range, for flat position



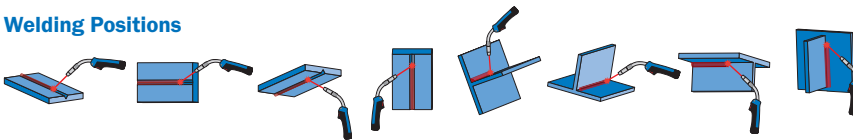
### Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	Fe	Nb+Ta	Ti	Co	W	V
0.031	0.46	0.31	0.004	0.001	0.01	63.5	22.4	8.3	0.7	3.6	0.14	-	-	-

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)0°C	CV(J)-196°C
Guaranty	501	781	45	61	54
	min.420	min.690	min.25		

### Welding Positions



### Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-