

## Classifications

ASME II C SFA 5.14

EN ISO 18274

EQNiCrMo-3

B Ni 6625 (NiCr22Mo9Nb)

## Characteristics and typical fields of application

SOUDOTAPE 625 is a nickel chromium molybdenum strip developed for the single and multi layer strip cladding of alloy 625. Electroslag Strip Cladding is performable either in single or two layers depending on RECORD flux selection.

With high productivity flux RECORD ES6625, weld overlay is achievable in two layer with total over thickness below 7mm at 300mm/min

With single layer flux RECORD EST 625-1, weld overlay is achievable in single layer with total over thickness below 4mm.

Submerged Arc Strip Cladding agglomerated flux RECORD NiCr T cladding deposit is compliant with UNS N06625 (Fe 5%max) with only two layers.

Extremely resistant to stress corrosion cracking.

High resistance to corrosive environment with pitting (PREN > 50).

Suitable for reactors and vessels for chemical, steelmaking and nuclear applications.

## Typical analysis

	C	Si	Mn	Cr	Ni	Mo	Nb	Fe
wt.-%	0.01	0.1	0.1	22.2	Rem.	8.7	3.6	0.3

## Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD ES 6625	ES A FB 2B
ESW	RECORD ES 6625-1	ES A FB 2B
ESW	RECORD EST 625-1	ES A FB 2B
ESW	RECORD EST 625-1 LD	ES A FB 2B
SAW	RECORD NFT 201	S A AB 2B

## Packaging

Size(s) in mm	Type	Weight
30 x 0,5	Coil	25 - 30 kg
60 x 0,5	Coil	50 - 60 kg
90 x 0,5	Coil	75 - 90 kg

Other sizes and coil weights on request.