

## NIMROD 625KS

MMA (SMAW)

## BASIC MMA PIPE-WELDING ELECTRODE FOR 625

## PRODUCT DESCRIPTION

MMA electrode with a basic flux system made on a 625 core wire. The electrode is designed to combine easy operation with the deposition of high quality, radiographically sound weld metal and a finished bead of good appearance.

Nimrod 625KS is optimised for DC+ welding in all positions including pipework qualified in the ASME 6G position.

Recovery is about 120% with respect to core wire, 65% with respect to whole electrode.

## CLASSIFICATIONS

AWS A5.11M	ENiCrMo-3
ISO 14172	E Ni 6625
APPROVALS	TÜV, DNV

## ASME IX QUALIFICATION

QW432 F-No 43

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

## CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Nb	Fe	Mo	Cu
Min.	--	0.5	--	--	--	20.0	55	3.15	--	8.0	--
Max.	0.10	1.0	0.75	0.015	0.020	23.0	--	4.15	2.5	10.0	0.50
Typical	0.04	0.7	0.4	0.005	0.005	22	63	3.2	<1.5	9.3	0.01

## ALL-WELD MECHANICAL PROPERTIES

Typical values as welded	Min. *	RT	+160°C
Tensile strength (MPa)	760	800	725
0.2% proof strength (MPa)	420	500	440
Elongation [%] 4d	30	40	33
5d	27	38	31
Reduction of area [%]	--	40	32
Impact ISO-V(I) -196°C	--	60	--
Hardness (HV) as welded	--	250	--
work-hardened	--	450	--

\* Cannot meet TS > 827MPa required by cold rolled ASTM N06625 Grade 1, but meets PS > 414MPa and properties of hot rolled grades. Cast CW-6MC solution annealed 1175°C + WQ requires TS > 485MPa .

## TYPICAL OPERATING PARAMETERS, DC +VE

Diameter (mm)	2.5	3.2	4.0	5.0
min. A	60	70	100	130
max. A	80	110	155	210

## PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	300	NIM625KS-25	242	726	4.3	12.9
	3.2	300	NIM625KS-32	160	480	4.2	12.6
	4.0	350	NIM625KS-40	111	333	5.0	15.0
	5.0	450	NIM625KS-50	CONSULT US			

Redrying : 200 – 250°C/1-2h to restore to as-packed condition. Maximum 350° C, 3 cycles, 10h total.

## FUME DATA (WT % TYPICAL)

Fe	Mn	Ni	Cr	Mo	Cu	F	OES (mg/m <sup>3</sup> )
1	4	9	6	1	0.1	20	0.8

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to [www.specialalloys.eu](http://www.specialalloys.eu) for any updated information.