

	TECNHICAL DATA SHEET	FT-DQ66
	EUROTROD LR 625	PÁG. 1/1

CLASSIFICATION:

CERTIFIED COMPANY:

AWS A5.11: E NiCrMo-3
ISO 14172: E Ni 6625 (NiCr22Mo9Nb)



Management System
ISO 9001:2015

www.tuv.com
ID 1100008183



DESCRIPTION:

Basic coated electrode. Welding in all positions except vertical down. Stable arc. Used for Nickel based welds type 625-825 and cryogenic applications. High elongation.

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	Cr	Fe	Nb	Ni		
0,04	0,4	0,8	22	1,5	4	rest		

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	CHARPY V (J)	
			+ 20 °C	+ 20 °C
>450	>760	>35	> 80	> 80

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (Kg)
2,5	300	50 – 70	DC	80	2,0
3,2	350	75 – 95	DC	78	2,5
4,0	350	100 – 130	DC	50	2,5

WELDING POSITIONS:

