SUPERCORE® 625P
Nickel • AWS ENiCrMo3T1-4

KEY FEATURES
- Smooth all position weldability
- Vacuum sealed foil package
- Excellent slag removal
- Q2 Lot® - Certificate showing actual deposit composition available online

WELDING POSITIONS
All

SHIELDING GAS
75-80% Argon / Balance CO₂
100% CO₂

DIAMETERS / PACKAGING

<table>
<thead>
<tr>
<th>Diameter mm (in)</th>
<th>15 kg (33 lb) Spool</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2 (0.047)</td>
<td>ED034130, SC625P-12*</td>
</tr>
</tbody>
</table>

*The Metrode part number will be replacing the current ED0 numbers after the inventory has been depleted.

CONFORMANCES
AWS A5.34/A5.34M (R2007) ENiCrMo3T1-4
UNS W86625

TYPICAL APPLICATIONS
- Furnace Equipment
- Petrochemical
- 9% Ni for LNG storage tanks
- Dissimilar welds between Nickel alloys, stainless steels, and mild steel.

MECHANICAL PROPERTIES
- As Required per AWS A5.34

<table>
<thead>
<tr>
<th>Requirements</th>
<th>Yield Strength MPa (ksi)</th>
<th>Tensile Strength MPa (ksi)</th>
<th>Elongation %</th>
<th>Charpy V-Notch J (ft•lbf) @ 20°C (68°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>AWS ENiCrMo3T1-4</td>
<td>–</td>
<td>690 min</td>
<td>25 min</td>
<td>–</td>
</tr>
</tbody>
</table>

Typical Results
- As-Welded
  | 500 | 770 | 46 | 95 |

DEPOSIT COMPOSITION
- As Required per AWS A5.34

<table>
<thead>
<tr>
<th>Requirements</th>
<th>%C</th>
<th>%Mn</th>
<th>%Si</th>
<th>%S</th>
<th>%P</th>
<th>%Cr</th>
</tr>
</thead>
<tbody>
<tr>
<td>AWS ENiCrMo3T1-4</td>
<td>0.10 max</td>
<td>0.50 max</td>
<td>0.50 max</td>
<td>0.015 max</td>
<td>0.02 max</td>
<td>20.0 - 23.0</td>
</tr>
</tbody>
</table>

Typical Results
- %Ni | %Mo | %Nb | %Cu | %Ti | %Fe |
| 58.0 min | 8.0 - 10.0 | 3.15 - 4.15 | 0.50 max | 0.40 max | 5.0 max |

Typical Results
- 66.0 | 8.50 | 3.40 | 0.02 | 0.20 | 0.5 max |

TYPICAL OPERATING PROCEDURES

<table>
<thead>
<tr>
<th>Diameter in (mm)</th>
<th>Voltage (volts)</th>
<th>Amperage</th>
<th>Typical</th>
<th>Stickout in (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2 (0.047) DC+</td>
<td>25 - 28V</td>
<td>150 - 180A</td>
<td>160A, 26V</td>
<td>5/8-1” (15-20 mm)</td>
</tr>
</tbody>
</table>

(1)Typical all weld metal. (2)Measured with 0.2% offset. (3)See test results disclaimer. NOTE: Additional test data available upon request.
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