

AWS CLASSIFICATION: A5.34: 2007

ISO: TNi 6625-11/-14 AWS: ENiCrMo3T1-1/-4

DESCRIPTION

Stoody 625-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ or Argon/CO₂ mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications.

TYPICAL DEPOSIT CHARACTERISTICS

Tensile Strength	112 ksi (773 MPa)
Yield Strength	72 ksi (497 MPa)
Elongation	38%
Charpy Impact Toughness at -320°F (-196°C)	48 ft - lbs (67 Joules)
Lateral Expansion	35 mils (0.89mm)

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	0.03
Manganese	0.4
Silicon	0.3
Chromium	22.0
Molybdenum	9.2
Iron*	3.0
Niobium	3.8
Sulfur	0.002
Phosphorus	0.010
Nickel	Balance

* For Iron <1%, please request Stoody 625LI-T1 (PDS SP-029).

TYPICAL APPLICATIONS

Typical applications include:

- Joining nickel-chromium-molybdenum alloys
- Clad side of joints in steels clad with nickel-chromium-molybdenum weld metal
- Surfacing steel with nickel-chromium-molybdenum weld metal
- Joining steels to nickel based alloys
- Joining 9% nickel steel for cryogenic applications

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, in. (mm)	.045 (1.2)
Amperage (DCEP)	150 – 200
Wire Feed Speed (ipm)	290 – 400
Voltage	25 – 26
Shielding Gas	75% Ar -25% CO ₂ or 100%CO ₂
Wire Extension, in (mm)	1/2 (12)

Diameter, in. (mm)	1/16 (1.6)
Amperage (DCEP)	200 – 250
Wire Feed Speed (ipm)	190 – 275
Voltage	26 – 27
Shielding Gas	75% Ar -25% CO ₂ or 100% CO ₂
Wire Extension, in (mm)	1/2 (12)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.045" (1.2mm)	33# wire basket, LLW	11872500
1/16" (1.6mm)	33# wire basket, LLW	11872400

Stoody Company

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NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data.
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