



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
6025
625 Tig

INTERNATIONAL CLASSIFICATIONS

Aws 5.14 ERNiCrMo-3 EN ISO 18274: S Ni6625 (NiCr22Mo9Nb)
DIN 1736: SG-NiCr21Mo9Nb (2.4831)

FEATURES & APPLICATIONS

6025 is used for gas tungsten arc welding of Inconel® alloy 625, Incoloy® alloy 825, Incoloy® alloy 25-6Mo and a range of high alloy austenitic and super austenitic stainless steels. It is also used for surfacing of steel, for welding 9% nickel steels, and for welding various corrosion resistant alloys such as alloy 20. The weld metal has high strength over a broad temperature range and has resistance to localized attack such as pitting and crevice corrosion.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Cr	Mo
0.01	0.05	.20	0.008	0.001	0.05	0.01	Bal.	0.12	22.3	8.8

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	114,000 PSI (790 MPa)
Yield Strength	85,000 PSI (590MPa)
Elongation	27%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC- (100% Argon gas should be used to minimize burn-off of the tungsten electrode)

Welding Techniques: Insure welding surface is free of contamination.

Recommended Amperage Settings:

Diameter Inches (mm)	Volts	Amps
1/16 (1.6)	15-18	170-190
3/32 (2.5)	16-19	180-200
1/8 (3.2)	18-20	95-210