SHUBER E 525

NICKEL BASE ALLOY

DESCRIPTION

ELECTRODE DESIGNED FOR WELDING NICKEL CHROME ALLOYS USED IN CRYOGENIC AND HIGH TEMPERATURE APPLICATIONS. SPECIFICALLY FOR WELDING INCONEL 625 OR 601 AND FOR SURFACING CARBON STEEL & 9% NICKEL STEELS. It is also used for joining dissimilar combinations of steels or stainless steels to nickel-iron-chromium alloys such as Incoloy 800, 801 or 825 in furnace equipment, petrochemical and power generation plants. Also for overlays on pump, valves and shafts used in offshore and marine environments where high pitting resistance are essential.

SPECIAL FEATURES

- High tolerance to weld metal dilution.
- Exhibits exceptional strength up to 1100°C.
- Resistance to localized attack such as pitting & crevice corrosion.

APPLICATION INSTRUCTIONS

No preheating is required. Keep maximum interpass temperature of 250°C. When welding superaustenitic alloys the interpass temperature should be controlled to a maximum of 100°C and keep welding current as low as possible.

TECHNICAL DATA

TENSILE STRENGTH: 76 kg/mm^2 (110,000 psi)
ELONGATION, (4D): 30 %

RECOMMENDED CURRENT:

AC or DC+ (Reverse Polarity)	DIAMETER	AMPS
	2.4 mm (3/32")	50 - 70
	3.2 mm (1/8")	90 - 110
	4.0 mm (5/32")	120 - 140

Available: MMA (E 525) AWS A5.11 ENiCrMo-3
TIG (ER 525) **AWS A5.14 ERNiCrMo-3**