

# CSI-625

For Ni and Ni alloyed steel

AWS A5.11 ENiCrMo-3  
KS D 7021 DNiCrMo-3  
JIS Z3224 DNiCrMo-3

## Applications

For high temperature and creep resisting steel, heat resisting and dissimilar joint.

## Characteristics

CSI-625 is designed to match INCONEL 625, INCOLOY 825, INCOLOY 25-6Mo and other Mo containing stainless steel. Suitable in pressure vessel fabrication for -196°C to 550°C, otherwise up to the scaling resistance temperature of 1200°C.

The weld metal has high strength at room and elevated temperatures and has exceptional corrosion resistance, including resistance to pitting, crevice corrosion and polythionic acid stress-corrosion cracking. CSI-625 is useful for many dissimilar joints involving INCONEL alloys, INCOLOY alloys, stainless steels, low-alloy steel, and carbon steel.

## Notes on usage

- (1) Use recommended current range. if not it will be much spatters and undercut.
- (2) Keep the arc as short as possible.
- (3) Weaving width should be within two and a half times electrode's diameter.
- (4) When the electrodes have absorbed moisture, dry them at 250~280°C for 30~60 minutes before use.

## Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Fe	Ni	Cr	Nb	Mo
0.03	0.7	0.54	0.001	0.002	2.1	61.6	21.9	3.8	8.5

## Typical mechanical properties of weld metal

TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %	IV (J)
		-196°C
774(79)	40.2	62

## Size & recommended current range (DC+)

Dia. (mm)		3.2	4.0
	L (mm)	350	350
Amp.	F	90-120	120-150
	V&OH	80-110	100-140