

# TASETO Welding Materials

Ni-Base Alloy Electrodes

For Flux Cored Arc Welding

## GFW625

Applicable Specification  
AWS A5.34 TNi6625-04

### ● Applications and Characteristics

TASETO GFW625 can be applied to welding of nickel alloy 625 (UNS N06625), welding of nickel alloy 800 (UNS N08800), welding on the clad side of nickel alloy 625 (UNS N06625) or nickel alloy 825 (UNS N08825) clad steel, and overlay welding of carbon steel.

As GFW625 has high PRE value and good resistivity for pitting corrosion, it can be applicable to welding of UNS S31254 class austenitic super stainless steel.

### ● Notes on Usage

\* To minimize crater crack, fill craters with filler metal and remove crater crack with grinder.

### ● Chemical Composition of All Weld Metal(%)

	C	Mn	Fe	P	S	Si	Cu
Typical	0.031	0.05	3.43	0.001	0.001	0.26	0.12

  

	Ni	Ti	Cr	Cb+Ta	Mo
Typical	60.17	0.24	22.78	3.25	9.71

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	481	744	45

### ● Sizes Available and Recommended Welding Conditions(DCEP)

Size (mm)	Flat			Horizontal		
	Current (A)	Voltage (V)	Speed (mm/min)	Current (A)	Voltage (V)	Speed (mm/min)
1.2	160~190	26~31	250~350	130~160	25~28	300~400