

CWR-825 Welding Wire and Rod

CWR-825 is used for welding of nickel-iron-chromium-molybdenum-copper alloys. It can also be used overlay cladding where similar chemical composition is required.

CONFORMANCES

AWS A5.14 : ERNiFeCr-1
ASME SFA-5.14 : ERNiFeCr-1
UNS : N08825

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Ti	%Fe	%Mn
0.05 max	19.5 – 23.5	38.0 – 46.0	2.5 – 3.5	0.60 – 1.20	22.0 min	1.0 max
%Si	%P	%S	%Cu	%Al	Total Others	
0.50 max	0.03 max	0.03 max	1.5 – 3.0	0.20 max	0.50 max	

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength : 61,000 psi
Tensile Strength : 88,000 psi
Elongation : 34 %

TYPICAL WELDING PARAMETERS*

Process	Diameter	Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"			100% Ar
	3/32"			100% Ar
	1/8"			100% Ar
MIG (GMAW)	.035"	26 – 29	150 – 190	75% Ar – 25% He
	.045"	28 – 32	180 – 220	75% Ar – 25% He
Sub Arc (SAW)	.093"	29 – 32	300 – 350	
	.125"	29 – 32	400 – 550	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<p>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</p> <p>BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.</p>

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