

# TMS-625

AWS A5.34 ENiCrMo3T0-4 mod.

## Characteristics and Applications:

TMS-625 is a nickel-based metal core wire for welding Ni-alloyed steels, such as alloy 625 or 9% Ni for low temperature storage tank. This wire is designed for 100%Ar shielding welding. It can be welded for cladding and joint with NiCrMo alloy.

## Notes on usage:

1. Before welding, the base metal should be cleaned from oil, rusty, moisture and the welding place should have the proper protection from the wind.
2. Use 100%Ar shielding gas. Maintain the flow rate not less than 20L/min when wire diameter is 1.2 mm.
3. Trailer shield is required to ensure the weld pool completely shielded until solidification is complete and no porosity problem.
4. Keep dry while in storage and delivery.

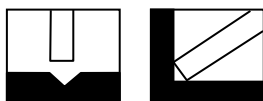
## Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni	Mo	Fe	Nb
0.008	0.034	0.113	0.005	0.001	21.14	63.93	9.071	1.446	3.712

## Typical mechanical properties of weld metal:

Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Charpy V-Notch -196°C (J)
501	788	46	96

## Welding position:



## Size and recommended current range (DC<+>)

Stick out:15-20(mm),flow rate:20-25(l/mm):

Parameters	Diameter (mm)	1.2
F, HF		200A-240A/22V-28V

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