



Manufacturers of Custom Welding Lines for Resale  
www.selectrode.com

**SELECTRODE**  
**6025**  
625 Tig

**INTERNATIONAL CLASSIFICATIONS**

**Aws 5.14 ERNiCrMo-3      EN ISO 18274: S Ni6625 (NiCr22Mo9Nb)**  
**DIN 1736: SG-NiCr21Mo9Nb (2.4831)**

**FEATURES & APPLICATIONS**

6025 is used for gas tungsten arc welding of Inconel® alloy 625, Incoloy® alloy 825, Incoloy® alloy 25-6Mo and a range of high alloy austenitic and super austenitic stainless steels. It is also used for surfacing of steel, for welding 9% nickel steels, and for welding various corrosion resistant alloys such as alloy 20. The weld metal has high strength over a broad temperature range and has resistance to localized attack such as pitting and crevice corrosion.

**ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)**

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Cr	Mo
0.01	0.05	.20	0.008	0.001	0.05	0.01	Bal.	0.12	22.3	8.8

**TYPICAL MECHANICAL PROPERTIES**

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	114,000 PSI (790 MPa)
Yield Strength	85,000 PSI (590MPa)
Elongation	27%

**WELDING CURRENT & INSTRUCTIONS**

**Recommended Current:** DC- (100% Argon gas should be used to minimize burn-off of the tungsten electrode)

**Welding Techniques:** Insure welding surface is free of contamination.

**Recommended Amperage Settings:**

Diameter Inches (mm)	Volts	Amps
1/16 (1.6)	15-18	170-190
3/32 (2.5)	16-19	180-200
1/8 (3.2)	18-20	95-210