

CORODUR® TS 625

In addition to joining and cladding stainless, heat resistant and cold tenacious steels, The CORODUR® TS-625 is used to weld dissimilar materials such as low alloyed steels with Ni-base or Cu- base alloys. The austenitic deposit is insensitive to hot-cracking and free of embrittlement at both high and low temperature

extremes, non-scaling up to 1100 °C, and cold tough down to -196 °C. No diffusion of carbon into the weld metal at high temperatures. It is frequently used in service-temperatures of more than 300 °C in the chemical and petro-chemical industries, glassworks, civil engineering, repairing and maintenance workshops.



1.4563 2.4856
1.4562 2.4858
1.4529 1.5662

TYPICAL ALL WELD METAL ANALYSIS (%)

C	Si	Mn	Cr	Ni	Mo	Nb	Fe
0,04	0,3	0,4	22,0	Basis	9,0	3,5	< 6

Tensile strength R_m N/mm ²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact strength (J)
780	500	40	70 @ -196° C

Recommended shielding gas: M21 Ar + 15-25% CO₂

FORMS OF DELIVERY

Diameter	Units	Shielding gas
1,2	BS 300	Argon + Co ₂
1,6	BS 300	Argon + Co ₂

Other dimensions on request

RUST, ACID AND HEAT
RESISTANT ALLOYS

Rev. 01.01-2021.1