

## AI-0325

### Specifications

**AWS/ASME** A5.11, E NiCrMo-3

**DIN** 1736, 2.4831

**MIL-RN625** & EN 625

### Description and Applications

**AI-0325** is a nickel-chromium alloy covered electrode that is used for its high strength and outstanding corrosion resistance and is designed to weld to itself or to other materials. One of the features of this alloy is that the welded deposits require no further postweld heat treatments to maintain their high strength and ductility.

**AI-0325** is used in various industries such as the marine and aerospace industry and also in chemical processing where it is an excellent choice for its resistance to pitting and crevice corrosion.

It has excellent corrosion resistance to a wide variety of severe corrosive environments. The nickel and chrome combination provide resistance to oxidising chemicals, the high molybdenum supplies resistance to pitting and crevice corrosion. The niobium stabilizes the alloy during welding, thus, preventing inter-granular cracking.

Applications include propeller blades, submarine motors, springs and seals for submerged controls, instrument components, engine exhaust systems, aircraft components.

### Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	P	S	Mo	Nb
0.018	0.19	0.21	21.70	Bal	2.30	0.009	0.007	9.10	3.40

### Mechanical Properties of Weldmetal

	As Welded
Tensile Strength:	> 750 MPa
Elongation A5:	>30%
Impact Energy, Charpy V:	20°C 150J -190°C 70J
Hardness:	220 HV

### Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC(+)	45-60
3.2	DC(+)	65-95
4.0	DC(+)	90-120

MIG : 1.20 & 1.60 mm diameter

TIG : 1.60 & 2.40 mm diameter



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### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up.

### Disclaimer

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