

## COR® MET QWP625 FLUX COATED TIG WIRE

### DESCRIPTION

A 20" alloy 625 TIG wire with a flux coating that allows TIG welding open root passes, and eliminates the need for backing or purging. All wire is identified with the grade marked on the end of rod.

### APPLICATIONS

For root pass welding of alloy 625 and similar nickel alloy piping without use of a purge or backing gas.

### PROCEDURE

Flux Coated TIG will produce a protective slag on the inside of the plate/pipe that will protect the weld from oxidation. It will eventually be released and may not be easily accessible to be removed. We recommend that you conduct your own qualification procedure, and as you may not be able to use flux coated TIG on critical applications, if you cannot remove the slag from the inside of the fabrication. See additional procedure information on second page.

### WELDING PARAMETERS

Wire Size	Tungsten Size	Amperage	Current	Optional
3/32"		80-200	DCEN	Pulse Current
1/8"		90-250	DCEN	Pulse Current

### CHEMISTRY

C	Mn	Si	Cr	Ni	Mo	Nb	Fe	P	S	Cu	TO
0.10	1.0	0.75	20.0-	55.0	8.0-	3.15-	7.0	0.03	0.02	0.50	0.50
Max	max	max	23.0	min	10.0	4.15	max	max	max	max	max

### MECHANICAL PROPERTIES

Tensile	110 ksi min
Elongation	30% min

### CLASSIFICATION

No AWS specification applies to this product. The core wire conforms to AWS A5.14, Class ERNiCrMo-3.