

# Specification Sheet: Alloy 625

(UNS N06625) W. Nr. 2.4856

## An Austenitic Nickel-Chromium-Molybdenum-Niobium Alloy with Outstanding Corrosion Resistance and High Strength from Cryogenic Temperatures to 1800°F (982°C)

Alloy 625 is an austenitic nickel-chromium-molybdenum-niobium alloy possessing a rare combination of outstanding corrosion resistance coupled with high strength from cryogenic temperatures to 1800°F (982°C).

The strength of Alloy 625 is derived from the solid-solution hardening of the nickel-chromium matrix by the presence of molybdenum and niobium. Therefore, precipitation-hardening treatments are not required.

The chemical composition of Alloy 625 is also responsible for its outstanding corrosion resistance in a variety of severe operating environments along with resistance to oxidation and carburization in high temperature service. The alloy is resistant to pitting, crevice corrosion, impingement corrosion, intergranular attack and is almost immune to chloride stress corrosion cracking.

Alloy 625 can be easily welded and processed by standard shop fabrication practices.

### Standards

ASTM ..... B 443  
ASME ..... SB 443  
AMS ..... 5599

### Oxidation Resistance

The oxidation and scaling resistance of Alloy 625 is superior to a number of heat resistant austenitic stainless steels such as 304, 309, 310 and 347 up to 1800°F (982°C) and under cyclic heating and cooling conditions. Above 1800°F (982°C), scaling can become a restrictive factor in service.

### Applications

- Aerospace Components—bellows and expansion joints, ducting systems, jet engine exhaust systems, engine thrust-reversers, turbine shroud rings
- Air Pollution Control—chimney liners, dampers, flue gas desulfurization (FGD) components
- Chemical Processing—equipment handling both oxidizing and reducing acids, super-phosphoric acid production
- Marine Service—steam line bellows, Navy ship exhaust systems, submarine auxiliary propulsion systems
- Nuclear Industry—reactor core and control rod components, waste reprocessing equipment
- Offshore Oil and Gas Production—waste flare gas stacks, piping systems, riser sheathing, sour gas piping and tubing
- Petroleum Refining—waste flare gas stacks
- Waste Treatment—waste incineration components

### Chemical Analysis

Weight % (all values are maximum unless a range is otherwise indicated)

Nickel	58.0 min.	Silicon	0.50
Chromium	20.0 min.–23.0 max.	Phosphorus	0.015
Molybdenum	8.0 min.–10.0 max.	Sulfur	0.015
Iron	5.0	Aluminum	0.40
Niobium (plus Tantalum)	3.15 min.–4.15 max.	Titanium	0.40
Carbon	0.10	Cobalt (if determined)	1.0
Manganese	0.50		

### Mechanical Properties

Typical Values at 68°F (20°C)

Yield Strength 0.2% Offset		Ultimate Tensile Strength		Elongation in 2 in.	Hardness
psi	(MPa)	psi	(MPa)	%	
65,000	448	125,000	862	50	200 Brinell

### Physical Properties

#### Density

0.305 lbs/in<sup>3</sup>  
8.44 g/cm<sup>3</sup>

#### Specific Heat

0.102 BTU/lb-°F (32–212°F)  
427 J/kg-°C (0–100°C)

#### Modulus of Elasticity

30.1 x 10<sup>6</sup> psi  
207.5 GPa

#### Thermal Conductivity 212°F (100°C)

75 BTU-in/ft<sup>2</sup>-h-°F  
10.8 W/m-°C

#### Melting Range

2350–2460°F  
1290–1350°C

#### Electrical Resistivity

50.8 Microhm-in at 70°F  
128.9 Microhm-cm at 21°C



**SANDMEYER STEEL COMPANY**

ONE SANDMEYER LANE • PHILADELPHIA, PA 19116-3598  
800-523-3663 • +1-215-464-7100 • FAX +1-215-677-1430

[www.SandmeyerSteel.com](http://www.SandmeyerSteel.com)

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## Mean Coefficient of Thermal Expansion

Temperature Range			
°F	°C	in/in/°F	cm/cm °C
200	93	$7.1 \times 10^{-6}$	$12.8 \times 10^{-6}$
400	204	$7.3 \times 10^{-6}$	$13.1 \times 10^{-6}$
600	316	$7.4 \times 10^{-6}$	$13.3 \times 10^{-6}$
800	427	$7.6 \times 10^{-6}$	$13.7 \times 10^{-6}$
1000	538	$7.8 \times 10^{-6}$	$14.0 \times 10^{-6}$
1200	649	$8.2 \times 10^{-6}$	$14.8 \times 10^{-6}$
1400	760	$8.5 \times 10^{-6}$	$15.3 \times 10^{-6}$
1600	871	$8.8 \times 10^{-6}$	$15.8 \times 10^{-6}$
1700	927	$9.0 \times 10^{-6}$	$16.2 \times 10^{-6}$

## Corrosion Resistance

The highly alloyed chemical composition of Alloy 625 imparts outstanding corrosion resistance in a variety of severely corrosive environments. The alloy is virtually immune to attack in mild conditions such as the atmosphere, fresh and sea water, neutral salts and alkaline solutions. Nickel and chromium provide resistance to oxidizing solutions and the combination of nickel and molybdenum supply resistance in non-oxidizing environments. Molybdenum also makes Alloy 625 resistant to pitting and crevice corrosion, while niobium acts as a stabilizer during welding to prevent intergranular cracking. The high nickel content of Alloy 625 makes it virtually immune to chloride stress corrosion cracking.

The alloy resists attack by mineral acids such as hydrochloric, nitric, phosphoric and sulfuric, and to alkalis and organic acids in both oxidizing and reducing conditions.

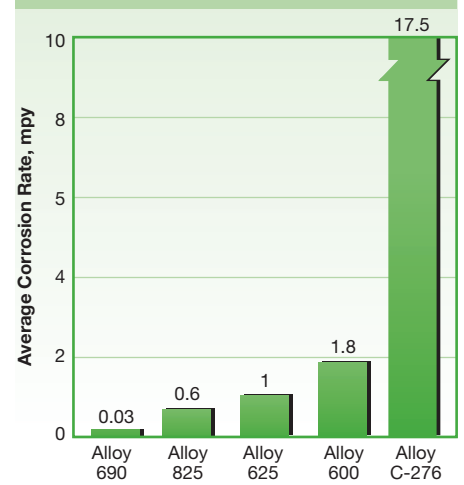
### Resistance of Nickel Alloys to Impingement Attack by Seawater at 150 ft/sec (45.7 m/s)

ALLOY	Corrosion/Erosion Rate	
	mpy	mm/a
Alloy 625	Nil	Nil
Alloy 825	0.3	0.008
Alloy K-500	0.4	0.01
Alloy 400	0.4	0.01
Nickel 200	40	1.0

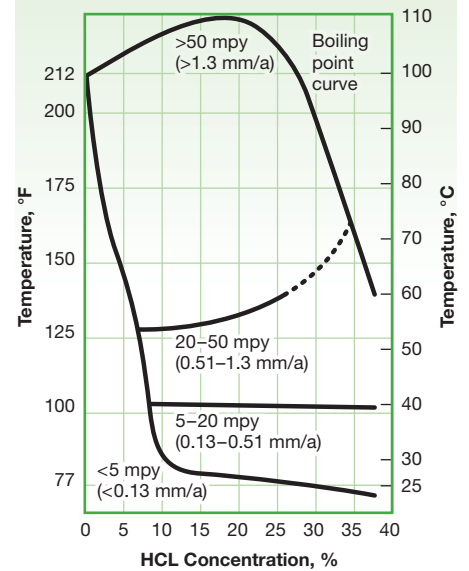
### Corrosion-Resistance of Nickel Alloys in Four 24-hour Tests in Boiling Acetic Acid

ALLOY	Acetic Acid Concentration	Corrosion/Erosion Rate	
		mpy	mm/a
Alloy 825	10%	0.60–0.63	0.0152–0.160
Alloy 625	10%	0.39–0.77	0.01–0.019
Alloy C-276	10%	0.41–0.45	0.011–0.0114
Alloy 686	80%	<0.1*	<0.01*

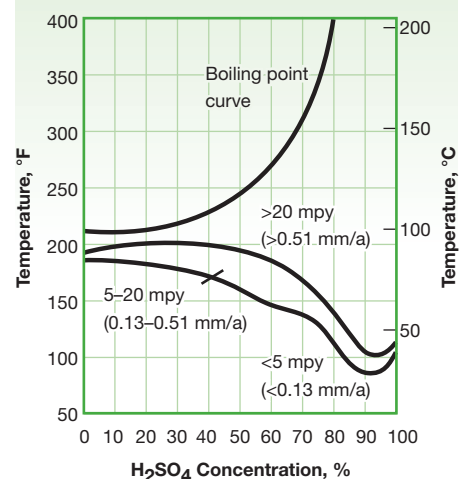
Average corrosion rates for nickel alloys in 10% nitric acid at boiling temperatures.



Iso-corrosion chart for Alloy 625 in hydrochloric acid.



Iso-corrosion chart for Alloy 625 in sulfuric acid.



The comparative PREN number for Alloy 625 is shown in the table below.

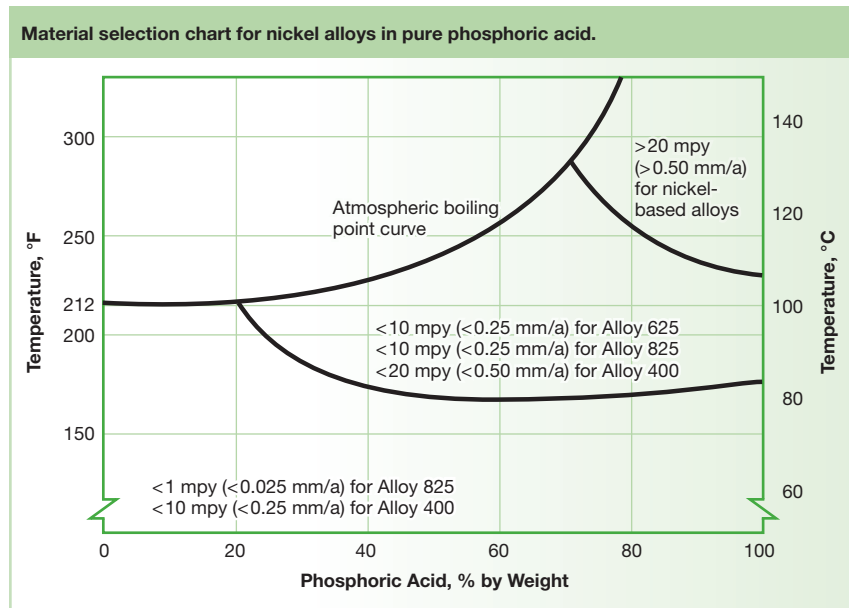
**Pitting Resistance Equivalency Numbers (PREN)\* for Corrosion-Resistant Alloys**

ALLOY	Ni	Cr	Mo	W	Nb	N	PREN
316 Stainless Steel	12	17	2.2	—	—	—	20.4
317 Stainless Steel	13	18	3.8	—	—	—	23.7
Alloy 825	42	21.5	3	—	—	—	26.0
Alloy 864	34	21	4.3	—	—	—	27.4
Alloy G-3	44	22	7	—	—	—	32.5
Alloy 625	62	22	9	—	3.5	—	40.8
Alloy C-276	58	16	16	3.5	—	—	45.2
Alloy 622	60	20.5	14	3.5	—	—	46.8
SSC-6MO	24	21	6.2	—	—	0.22	48.0
Alloy 686	58	20.5	16.3	3.5	—	—	50.8

\* (PREN) = %CR + 1.5 (%Mo + %W + %Nb) + 30 (%N)

**Corrosion-Resistance of Nickel Alloys in 24-hour Tests in Boiling 40% Formic Acid**

ALLOY	Corrosion Rate	
	mpy	mm/a
Alloy 825	7.9	0.2
Nickel 200	10.3–10.5	0.26–0.27
Alloy 400	1.5–2.7	0.038–0.068
Alloy 600	10.0	0.25
Alloy G-3	1.8–2.1	0.046–0.05
Alloy 625	6.8–7.8	0.17–0.19
Alloy C-276	2.8–2.9	0.07–0.074



**Fabrication Data**

Alloy 625 can be easily welded and processed by standard shop fabrication practices, however because the high strength of the alloy, it resists deformation at hot-working temperatures.

**Hot Forming**

The hot-working temperature range for Alloy 625 is 1650–2150°F (900–1177°C). Heavy working needs to occur as close to 2150°F (1177°C) as possible, while lighter working can take place down to 1700°F (927°C). Hot-working should occur in uniform reductions to prevent duplex grain structure

**Cold Forming**

Alloy 625 can be cold-formed by the standard shop fabrication practices. The alloy should be in the annealed condition. Work hardening rates are higher than the austenitic stainless steels.

**Welding**

Alloy 625 can be readily welded by most standard processes including GTAW (TIG), PLASMA, GMAW (MIG/MAG), SAW and SMAW (MMA). A post weld heat treatment is not necessary. Brushing with a stainless steel wire brush after welding will remove the heat tint and produce a surface area that does not require additional pickling.

**Machining**

Alloy 625 should preferably be machined in the annealed condition. Since Alloy 625 is prone to work-hardening, only low cutting speeds should be used and the cutting tool should be engaged at all times. Adequate cut depth is necessary to assure avoiding contact with the previously formed work-hardened zone.

The information and data in this product data sheet are accurate to the best of our knowledge and belief, but are intended for informational purposes only, and may be revised at any time without notice. Applications suggested for the materials are described only to help readers make their own evaluations and decisions, and are neither guarantees nor to be construed as express or implied warranties of suitability for these or other applications.



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