CEWELD®

NiCrMo 622

CATEGORY	GMAW-GTAW Solid wires
TYPE	Solid nickel base filler metal for GMAW welding of high corrosion resistant alloys.
APPLICATIONS	Ceweld NiCrMo-622 is used for welding of nickel-chromium-molybdenum alloys as well as for overlay cladding on carbon, low alloy, or stainless steels. They are also used for dissimilar joints between nickel-chromium-molybdenum alloys and stainless, carbon, or low alloyed steels. Also recommended for joining molybdenum-containing stainless steels, low alloyed steels and dissimilar welding between earlier mentioned type of steels.,
PROPERTIES	Ceweld NiCrMo-622 offers excellent corrosion resistance in oxidizing as well as reducing media in a wide variety of chemical process environments. It offers an outstanding resistance to stress corrosion cracking, pitting and crevice corrosion.
CLASSIFICATION	AWS A 5.14: ER NiCrMo-10 (UNS N06022) EN ISO 18274: S Ni 6022 (NiCr21Mo13Fe4W3) DIN: W.Nr. 2.4635 DIN 1736: SG-NiCr22Mo14W
SUITABLE FOR	ASTM, F574, B619, B622 and B626 - - All of which have UNS Number N06022. UNS: W86022 Welding of Inconel alloys 622 and 625, alloy 25-6Mo, and Incoloy 825 Hastelloy C4, C22, C-276 and Inconel 625, 2.4611
WELDING POSITIONS:	

FILLER METAL ANALYSES % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo	W	V	Co	Cu	Fe
0.003	0.2	0.03	21	56	13.5	3	0.15	1.5	0.1	4

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-196°C	Hardness HV
AW	500	740	44			130	220

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A) DC+	kg / spool	kg / pallet
0,8	16-26	80-180	15	1080
1,0	16-29	100-250	15	1080
1,2	18-29	125-290	15	1080

REDRYING TEMPERATURE	not required
GAS ACC. EN ISO 14175:	I1, I3 (Ar-He)