

## NiCrMo 622 TIG

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Solid nickel base filler metal for GTAW welding 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

**APPROVALS** CE

**WELDING POSITIONS:**



**FILLER METAL ANALYSIS % (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 <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HV
				-20°C	-40°C	-196°C	
AW	500	740	44			130	220

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters	Packing (kg)	Packing
	Current (A) DC-	single	master
1.6 x 915	50-80	4,54	27,24
2.0 x 915	70-110	4,54	27,24
2.4 x 915	110-180	4,54	27,24
3.2 x 915	150-250	4,54	27,24

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I1 (Ar)