

## E NiCrMo 622

**CATEGORY** SMAW Stick Electrodes

**TYPE** Nickel based electrode for extreme corrosive environments.

**APPLICATIONS** Ceweld NiCrMo-622 electrodes are 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 alloy steels.

**PROPERTIES** 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. High mechanical properties with excellent weldability on DC+.

**CLASSIFICATION**

AWS	A 5.11: E NiCrMo-10
EN ISO	14172: E Ni 6022
DIN: W.Nr.	2.4635
DIN	1736: EL-NiCr21Mo14W

**SUITABLE FOR** Inconel 622, 625, alloy 25-6Mo, incoloy 825, dissimilar joints of nickel alloys, hastelloy Alloy C276, C22, C4, 2.4611, Typical specifications for the nickel-chromium-molybdenum base metals are ASTM, F574, B619, B622 and B626 - - All of which have UNS Number N06022.

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Ni	C	Mn	Fe	S	W	Cr	Mo	P	Other
base	0.014	0.35	3.90	0.005	3.3	21.20	13.10	0.012	-

**MECHANICAL PROPERTIES**

Heat Treatment	Tensile strength		Yield strength		Elongation	Impact strength	Hardness
	(PSI)	(MPA)	(PSI)	(MPA)	(%)	(ft.lbs)	HRC / HV
AW	114	790	78.5	540	36	60	

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000	
2.4	229	50-75				
3.2	356	75-100				
4.0	356	80-140				