

NiCrMo 622

CATEGORY GMAW-GTAW Solid wires

TYPE Solid nickel base welding rod for tungsten inert gas welding

CLASSIFICATION
 AWS A 5.14: ER NiCrMo-10
 EN ISO 18274: S Ni 6022
 DIN: W.Nr. 2.4635
 DIN 1736: SG-NiCr22Mo14W

SUITABLE FOR 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. Typical specifications for the nickel-chromium-molybdenum base metals are ASTM, F574, B619, B622 and B626 - - All of which have UNS Number N06022. 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. UNS: W86022 Welding of Inconel alloys 622 and 625, alloy 25-6Mo, and Incoloy 825 Also recommended for joining molybdenum-containing stainless steels, low alloyed steels, Hastelloy C4, C22, C-276 and Inconel 625, 2.4611

WELDING POSITIONS:



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)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HV
				-20°C	-40°C	-196°C	
AW	500	740	44			130	220

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC-	kg / can	kg / 6pack	kg / 1000
1.6 x 915			4.54 / 5		
2.0 x 915			4.54 / 5		
2.4 x 915			4.54 / 5		
3.2 x 915			4.54 / 5		

GAS ACC. EN ISO 14175: Argon