CEWELD® NiCrMo 622 Tig

CATEGORY	GTAW Solid wires
TYPE	Tig filler metal for GTAW welding alloy C22 and similar grades.
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: ERNiCrMo-10
EN ISO	18274: S Ni 6022(NiCr21Mo13Fe4W3)
F-nr	43
FM	6
W.Nr.	2.4635

SUITABLE FOR

F574, B619, B622 and B626
W86022, N06022
Inconel alloys 622, 625, alloy 25-6Mo, Incoloy 825, Hastelloy C4, C22, C-276
2.4611

APPROVALS

No Approvals Found

WELDING POSITIONS:

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W	Co
0.01	0.08	0.3	21	56	13.5	4	3	1.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -196°C	Hardness Vickers
As Welded /	500	740	44	130	Avg. 220

WELDING PARAMETERS / PACKING

WELDING PARAMETERS D (MM)	WELDING PARAMETERS CURRENT (A) DC-	PACKING (KG) SINGLE	PACKING MASTER
1.6 X 1000	50-80	5	25
2.0 X 1000	70-110	5	25
2.4 X 1000	110-180	5	25
3.2 X 1000	150-250	5	25

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1