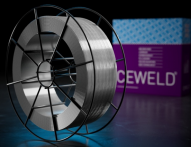




CEWELD NiCrMo 622

TYPE	GMAW welding wire for corrosion resistant C22 type of 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	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCrMo-10</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6022(NiCr21Mo13Fe4W3)</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> <tr> <td>W.Nr.</td> <td>2.4635</td> </tr> </table>	AWS	A 5.14: ERNiCrMo-10	EN ISO	18274: S Ni 6022(NiCr21Mo13Fe4W3)	F-nr	43	FM	6	W.Nr.	2.4635								
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EN ISO	18274: S Ni 6022(NiCr21Mo13Fe4W3)																		
F-nr	43																		
FM	6																		
W.Nr.	2.4635																		
SUITABLE FOR	<p>Nickel-based alloys such as alloy 22 or similar materials, dissimilar welding of nickel-based alloys to each other</p> <p>M no: 2.4602, 2.4605, 2.4610, 2.4819, 2.4856, 1.4565 NiCr23Mo16Al, NiCr21Mo14W, NiMo16Cr15W, NiMo16Cr16Ti, NiCr22Mo9Nb, X2CrNiMnMoNbN25-18-5-4, X1NiCrMoCuN25-20-7, Alloy 59, Alloy C22, Alloy C-276, Alloy C-4, Alloy 625, Alloy 24, Alloy 904hMo UNS: N06059, N06022, N10276, N06455, N0625, S34565 AL6XN, F574, B619, B622 and B626 W86022, N06022</p>																		
APPROVALS	No Approvals Found																		
WELDING POSITIONS																			
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Fe</th> <th>W</th> <th>Co</th> </tr> </thead> <tbody> <tr> <td>0.008</td> <td>0.08</td> <td>0.3</td> <td>22</td> <td>55</td> <td>13.5</td> <td>4</td> <td>3</td> <td>1.5</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Fe	W	Co	0.008	0.08	0.3	22	55	13.5	4	3	1.5
C	Si	Mn	Cr	Ni	Mo	Fe	W	Co											
0.008	0.08	0.3	22	55	13.5	4	3	1.5											
ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0.2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V -196°C</th> <th>Hardness Vickers</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>500</td> <td>740</td> <td>44</td> <td>130</td> <td>Avg. 220</td> </tr> </tbody> </table>	Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -196°C	Hardness Vickers	As Welded /	500	740	44	130	Avg. 220						
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As Welded /	500	740	44	130	Avg. 220														
REDRYING TEMPERATURE	Not required																		
GAS ACCORDING EN 14175	I1																		



CEWELD NiCrMo 622

NICRMO 622 0,2MM

Type	KG/unit	EANCode
D-100	0,1	8720663424310

NICRMO 622 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663418661

NICRMO 622 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663418678

NICRMO 622 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663418685