



# CEWELD NiCrMo 622 Tig

**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 <sub>P0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V -196°C	Hardness Vickers Avg. 220
As Welded /	500	740	44	130	

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** I1



# CEWELD NiCrMo 622 Tig

NICRMO 622 TIG 1,6 X  
1000MM

Type	KG/unit	EANCode
Tube	5	8720663418708

NICRMO 622 TIG 1,6 X  
914MM

Type	KG/unit	EANCode
Tube	4,54	8720663418692

NICRMO 622 TIG 2,0 X  
914MM

Type	KG/unit	EANCode
Tube	4,54	8720663418715

NICRMO 622 TIG 2,4 X  
1000MM

Type	KG/unit	EANCode
Tube	5	8720663418722

NICRMO 622 TIG 3,2 X  
914MM

Type	KG/unit	EANCode
Tube	4,54	8720663418739