









CEWELD E NiCrMo 622

TYPE	Nickel based electrode for extreme corrosive environments.								
APPLICATIONS	CEWELD E 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							
	F-nr	43							
	FM	6							
	W.Nr.	2.4635							
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.								
APPROVALS	No Approvals Found								
WELDING POSITIONS	<div> PA  PB  PC  PD  PE  PF</div>								
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	V	Fe	W
	0.01	0.1	0.8	21.5	55	13.5	0.1	4	3.3
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V -196°C			
	As Welded /	540	790	36	100	80			
REDRYING TEMPERATURE	300°C / 2 hr								
GAS ACCORDING EN 14175									



CEWELD E NiCrMo 622

E NICKRMO 622 2,4 X 229MM	Type	KG/unit	EANCode
	Can	2,27	8720663418623
E NICKRMO 622 3,2 X 356MM	Type	KG/unit	EANCode
	Can	2,27	8720663418630
E NICKRMO 622 4,0 X 356MM	Type	KG/unit	EANCode
	Can	2,27	8720663418647
E NICKRMO 622 4,8 X 356MM	Type	KG/unit	EANCode
	Can	2,27	8720663418654