



CEWELD E NiCrMo 622

TYPE	Nickel based electrode for extreme corrosive environments.(Type 622, Ni6022, ERNiCrMo-10)								
APPLICATIONS	CEWELD® E NiCrMo 622 is used for welding nickel-chromium-molybdenum alloys and for surfacing on carbon, low-alloy or stainless steels. It is also used for dissimilar joints between nickel-chromium-molybdenum alloys and stainless, carbon or low-alloy steels. Applications in aggressive corrosive media include flue gas desulphurization scrubbers, digesters and papermaking equipment, chemical process equipment, corrosion resistant coatings and aggressive offshore and petrochemical environments.								
PROPERTIES	CEWELD® E NiCrMo 622 offers excellent corrosion resistance in both oxidizing and reducing media in a variety of chemical process environments. It offers excellent resistance to stress corrosion cracking, pitting and crevice corrosion, as well as high mechanical properties with excellent weldability with DC+.								
CLASSIFICATION	AWS	A 5.11: E NiCrMo-10							
	EN ISO	14172: E Ni 6022							
	W.Nr.	2.4635							
	F-nr	43							
	FM	6							
SUITABLE FOR	ERNiCrMo-10, S Ni 6022 (NiCr21Mo13Fe4W3), 2.4602, 2.4635 2.4602, 2.4605, 2.4610, 2.4819, 1.4565 NiCr23Mo16Al, NiCr21Mo14W, NiMo16Cr15W, NiMo16Cr16Ti, NiCr22Mo9Nb, X2CrNiMnMoNbN25-18-5-4, X1NiCrMoCuN25-20-7 UNS: N06059, N06022, N10276, N06455, N0625, S34565 Inconel 622, 625, Alloy 25-6Mo, Incoloy 825, Hastelloy Alloy C276, C22, C4, 59, 24, 904hMo								
APPROVALS									
WELDING POSITIONS									
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
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness		
					RT	-196°C			
	As Welded	540	790	36	100	80	HRc		
REDRYING	300°C / 2 hr								
GAS ACC. EN ISO 14175									



CEWELD E NiCrMo 622

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