



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