



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

AWS	A 5.14: ERNiCrMo-10
EN ISO	18274: S Ni 6022(NiCr21Mo13Fe4W3)
W.Nr.	2.4635
F-nr	43
FM	6

SUITABLE FOR **Nickel-based alloys such as alloy 22 or similar materials, dissimilar welding of nickel-based alloys to each other**
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

APPROVALS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W	Co
0.008	0.08	0.3	22	55	13.5	4	3	1.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-196°C		
As Welded	500	740	44	130		220 HV

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD NiCrMo 622

NICRMO 622 0,2MM

Packaging	KG/unit	EanCode
D-100	0,1	8720663424310

NICRMO 622 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418661

NICRMO 622 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418678

NICRMO 622 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418685