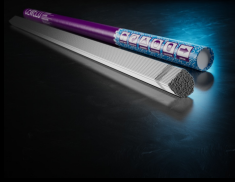


CEWELD NiCrMo 622 Tig

TYPE	Solid nickel base filler metal for GTAW welding high corrosion resistant alloys.																		
ANWENDUNGEN	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.																		
EIGENSCHAFTEN	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.																		
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCrMo-10</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6022(NiCr21Mo13Fe4W3)</td> </tr> <tr> <td>W.Nr.</td> <td>2.4635</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCrMo-10	EN ISO	18274: S Ni 6022(NiCr21Mo13Fe4W3)	W.Nr.	2.4635	F-nr	43	FM	6								
AWS	A 5.14: ERNiCrMo-10																		
EN ISO	18274: S Ni 6022(NiCr21Mo13Fe4W3)																		
W.Nr.	2.4635																		
F-nr	43																		
FM	6																		
GEEIGNET FÜR	<p>Nickel-based alloys such as alloy 22 or similar materials, dissimilar welding of nickel-based alloys to each other</p> <p>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 AL6XN W86022, N06022</p>																		
ZULASSUNGEN																			
SCHWEISSPOSITIONEN																			
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Fe</th> <th>W</th> <th>Co</th> </tr> </thead> <tbody> <tr> <td>0.01</td> <td>0.08</td> <td>0.3</td> <td>21</td> <td>56</td> <td>13.5</td> <td>4</td> <td>3</td> <td>1.5</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Fe	W	Co	0.01	0.08	0.3	21	56	13.5	4	3	1.5
C	Si	Mn	Cr	Ni	Mo	Fe	W	Co											
0.01	0.08	0.3	21	56	13.5	4	3	1.5											
MECHANISCHE GÜTEWERTE	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>500</td> <td>740</td> <td>44</td> <td colspan="2">130</td> <td>220 HV</td> </tr> </tbody> </table>	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		
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													
RÜCKTROCKNUNG	Not required																		
GAS ACC. EN ISO 14175	11																		



CEWELD NiCrMo 622 Tig

NICRMO 622 TIG 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663418708

NICRMO 622 TIG 1,6 X
914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663418692

NICRMO 622 TIG 2,0 X
914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663418715

NICRMO 622 TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663418722

NICRMO 622 TIG 3,2 X
914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663418739