

F574, B619, B622 and B626

W86022, N06022

| TYPE | Solid nickel base filler metal for GMAW welding of 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 | AWS A 5.14: ERNiCrMo-10 EN ISO 18274: S Ni 6022(NiCr21Mo13Fe4W3) W.Nr. 2.4635 F-nr 43 FM 6 | | | | | |
| GEEIGNET FÜR | 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 | | | | | |

ZULASSUNGEN

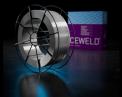
| SCHWEISSPOSITIONEN | | | | | | | | | | |
|-------------------------------------|-------------------|------|----------------------------|---------|----|-----------------------------------|------|----|---|----------|
| TYPICAL CHEMICAL | С | Si | м | n | Cr | Ni | Mo | Fe | W | Co |
| ANALYSIS OF THE FILLER METAL (%) | 0.008 | 0.08 | 0. | 3 | 22 | 55 | 13.5 | 4 | 3 | 1.5 |
| MECHANISCHE GÜTEWERTE | Heat Treatment | | R _{P0,2} (MPa) | | | Impact Energy (J) ISO-V -196°C | | | | Hardness |
| | As Welded | | 500 | 500 740 | | 130 | | | | 220 HV |
| RÜCKTROCKNUNG | Not require | d | | | | | | | | |

GAS ACC. EN ISO 14175

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Certilas THE FILLER METAL SPECIALIST

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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 |