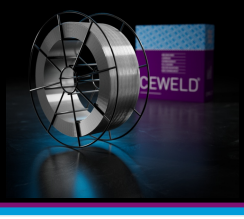



# CEWELD NiCrMo 622

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid nickel base filler metal for GMAW welding of high corrosion resistant alloys.

TOEPASSINGEN

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.,

EIGENSCHAPPEN

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.

CLASSIFICATIE

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

GESCHIKT VOOR

**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
F574, B619, B622 and B626
W86022, N06022

GOEDKEURINGEN

LASPOSITIES


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 |

MECHANISCHE WAARDEN

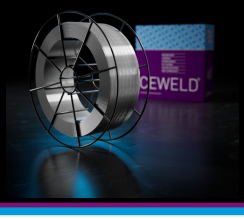
| Heat Treatment | $R_{P0,2}$ (MPa) | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V | Hardness |
|---|---|---|---|---|---|
| | | | | -196°C | |
| As Welded | 500 | 740 | 44 | 130 | 220 HV |

HERDROGEN

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 |