



CEWELD NiCrMo 622 Tig

TYPE Tig filler metal for GTAW welding alloy C22 and similar grades.

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 AL6XN
 W86022, N06022

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W	Co
0.01	0.08	0.3	21	56	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 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