

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 (%)

С	Si	Mn	Cr	Ni	Мо	Fe	W	Со
0.01	0.08	0.3	21	56	13.5	4	3	1.5

MECHANICAL PROPERTIES

Heat	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness	
Treatment				-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	Packaging	KG/unit	EanCode
1000MM	Tube	5	8720663418708
		•	
NICRMO 622 TIG 1,6 X	Packaging	KG/unit	EanCode
914MM	Tube	4,54	8720663418692
		•	
NICRMO 622 TIG 2,0 X	Packaging	KG/unit	EanCode
914MM	Tube	4,54	8720663418715
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NICRMO 622 TIG 2,4 X	Packaging	KG/unit	EanCode
1000MM	Tube	5	8720663418722
	'	,	
NICRMO 622 TIG 3,2 X	Packaging	KG/unit	EanCode
914MM	Tube	4.54	8720663418739