

622

Comparable specifications

ASME SFA A 5.14: ERNiCrMo-10
EN ISO 18274: Ni 6022 - NiCr21Mo13Fe4W3
BS 2901: Pt 5 NA 48
Werkstoff Nr.: 2.4635

Description and applications*

* *Illustrative, not-exhaustive list*

This grade may be used for:
welding of low carbon nickel-chromium-molybdenum alloys and chromium-nickel-molybdenum austenitic stainless steels;
welding of the clad side in steel clad with low carbon-nickel-chromium-molybdenum alloy;
joining of low-carbon-nickel-chromium-molybdenum alloys to steel and other nickel-based alloys;
surfacing of steel with nickel-chromium-molybdenum alloys.
welding of duplex and super duplex stainless steels;
applications in the chemical process industry and within pollution control equipments.

Weldable base materials*

* *Illustrative, not-exhaustive list*

Alloy 22, Alloy 625, Alloy 825, Alloy 926

All-weld metal mech. properties*

* *For reference only values*

Tensile strength (Rm): ≥ 690 N/mm²

Chemical composition*

* *For reference only values*

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Cr	Mo	V	W
max	max	2.00	max	max	max	max	49.00	max	20.00	12.50	max	2.50
0.010	0.50	6.00	0.020	0.010	0.08	0.50	min	2.50	22.50	14.50	0.30	3.50

Standard packaging data*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	15 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)

* *Other sizes and packing types are available upon request*

** *GMAW: gas metal arc welding; GTAW: gas tungsten arc welding*

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.