

NICROMIG 622

MIG/MAG Wires [GMAW]

Nickel alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 18274-A : S Ni 6022 (NiCr21Mo13Fe4W3) AWS A-5.14 : ER NiCrMo-10 W.Nr. : 2.4602		Power generation industry Petrochemical and chemical industry

- Nickel based MIG welding wire for welding 622 alloys as well as corrosion resistant NiCrMo steels.
- For cladding carbon, low alloyed or high alloyed steels.
- Provides excellent resistance to stress corrosion cracking, cracking and pitting.
- It can be used to join superaustenites and superduplexes.
- For all kinds of dissimilar joints.

Application

Corrosively aggressive environments.
 Flue gas scrubbers, desulfurization.
 Boilers and paper and celulosic industry.
 Hardfacing elements for work in marine and petrochemical environments.



Base material

AISI/ASTM	DIN	W.Nr.	Others
	NiCr21Mo14W	2.4602	
	NiCr20Mo15	2.4836	
	G-NiCr20Mo15	2.4697	
A494 CX2MW			C22
UNS N06022			C22
			Hastelloy™ Alloy C-22™
			Nicrofer™ 5621hMoW
			Inconel™ 622
			Alloy C4
UNS N06455			
	NiMo16Cr16Ti	2.4610	
			Hastelloy™ Alloy C-4
UNS S31254			
UNS S31266	X1CrNiMoCuNW24-22-6	1.4659	
UNSS32654	X1CrNiMoCuN24-22-8	1.4652	
UNS S34565	X2CrNiMnMoNbN25-18-5-4	1.4565	
UNS N08367	X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-7	1.4529	
UNS N08925			
UNS N08926	X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-7	1.4529	
			254SMO, 654SMO
			Uranus B66

Typical chemical composition %

Cr	Ni	Mo	Fe	W
20,5	59,0	14,0	2,3	3,2

Typical mechanical properties

Tensile strength Rm [N/mm²]	690
Hardness	210HB (after welding) /
Wire/rod type	solid
Welding current	
Welding positions	
Additional description	Pulse welding
Shielding gases acc. to EN ISO 14175	I1 - Ar / I3 - Ar + >0-95% He /
Remarks	Microstructure of high-nickel austenite. Interstitch temperature not higher than 100 [°C]. The amount of heat introduced is not more than 1 [kJ/mm].

Welding parameters and packing

∅	Weight of packet [kg]
1,0	15,0
1,2	15,0

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