Selectarc WELDING

SELECTARC Ni22

Nickel base Electrode
Highly Corrosion Resistant

Classification

AWS A5.11 : E NiCrMo-10 ISO 14172 : E-NI 6022 (NiCr21Mo13W3)
UNS : W86022

Characteristics

Basic coated electrode with an alloyed core wire for welding of nickel - base alloys (alloy 22) and other highly corrosion resistant NiCrMo, NiCrMoW alloys, as well as special stainless steel types. Stable arc, uniform drop transfer, easy to manupulate weld pool, uniform weld beads. Very resistant to sulphuric acid environment, highly concentrated chlorides and also in the presence of oxidizing solutions ($FeCl_3$, $CuCl_2$).

Applications

Welding of Offshore components, Boilers, Containers, Piping systems in the Chemical and Petrochemical industries as well as components of Flue gas de-sulfurizing plants.

Base Materials

UNS	ALLOY	DIN	Material N°
N06022	C - 22	NiCr21Mo14W	2.4602
N06059	59	NiCr23Mo16Al	2.4605
N10276	C-276	NiMo16Cr15W	2.4819
N06455	C-4	NiMo16Cr16Ti	2.4610
N06625	625	NiCr22Mo9Nb	2.4856
N08825	825	NiCr21Mo	2.4858
N08926	254SMo	X1NiCrMoCuN25 20 6	1.4529

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	Fe	W	Cu	Ni
0.010	0.10	0.50	21.50	13.50	2.70	2.70	0.10	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Rp0.2 (MPa)	% Elg A_5	Impact (KV) Temp.°C	J
AW	730	400	32	+ 20	73

Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 350	3.2 x 350	4.0 x 350
Current	(A)	50 - 70	70 - 100	90 - 120

Redrying of electrode for 1 hr at 250 - 300°C before use. Weld joint must be clean, free from grease, cracks .Guide electrodes with a slight inclined angle. Weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter). Nickel base alloys are welded without preheating. Maintain Interpass temperature : < 150°C.

1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

= +	~ 70 V

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