



TIG NI22

Old reference: TIG Ni22

Classification

AWS A5.14 : ERNiCrMo-10 Material N°: 2.4635
ISO 18274 : S-Ni6022 (NiCr21Mo13Fe4W3)

Description & Applications

Nickel alloy with high content of Cr and Mo for GTAW, which gives it exceptional corrosion resistance. It is particularly recommended for welding of C 276, C 22, other highly corrosion resistant Ni-alloys and special stainless steels.

Main applications: Works well in different environments, de-pollution (absorbers, chimneys), sea water and fertiliser, flue gas desulphurisation.

Base materials

UNS	Alloy	DIN	Material N°
N06022	C-22	NiCr21Mo14W	2.4602
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 Chemical Composition (%)

C	Si	Mn	Cr	Mo	W	Fe	P	S	Ni
0.01	0.05	0.1	21.4	13.2	3.0	3.0	<0.01	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
480	740	42	20°C 180

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon: 3-6 l/min

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