



### Characteristics and scope of application

- Filler metal for Alloy C22 and other corrosion resistant alloys. Also for dissimilar welds to other Ni alloys and austenitic steels
- Applicable for cladding of mild steels
- Excellent resistance against crevice and pitting attack

### Standard designations

DIN EN ISO 18274	AWS A5.14	DIN Mat.-No.
S Ni 6022 (NiCr21Mo13Fe4W3)	ERNiCrMo-10	2.4635

### Typical chemical composition of filler metal

	C	Cr	Mo	Ni	Fe	W	Al
Mass %	<0.01	22	13	Bal.	4.0	3.0	0.1

### All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	Rp0.2	R <sub>m</sub>	A <sub>5</sub>	ISO-V	
as welded	45 ksi	100 ksi	35%	70 J	

### Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, SG-AHe, SG-A-G (He 30% - H 2% - C ~0.1)
DC / -	SG-A, SG-AHe, SG-AH (max. 5% H <sub>2</sub> DC / -)

Low heat input and interpass temperature < 248°F . Stringer bead technique recommended. Reducing shielding gases are preferable for welding of corrosion resistant alloys.

Base materials
2.4602 – NiCr21Mo14W – Alloy C22 – UNS N06022
2.4610 – NiMo16Cr16Ti – Alloy C4 – UNS N06455
2.4819 - NiMo16Cr15Fe6W4 - Alloy C276 – UNS N10276

### Packaging (tolerances acc. to AWS A5.02)

Approvals on request

Diameter (in)		lbs/PU
1/16 - 1/8	X 36 in	11 / 22
0.035 – 0.045	BS 300 spool	33
0.06 – 1/8	K 415 / K 435 spool	55