



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	
	R _{p0.2}	R _m	A ₅	ISO-V	
as welded	310 MPa	690 MPa	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 ₂)

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 – NiMo16CSG-AH6Ti – Alloy C4 – UNS N06455

2.4819 - NiMo16CSG-AH5Fe6W4 - 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
0.8 / 1.0 / 1.2	BS 300 spool	33
1.6 / 2.4 / 3.2	K 415 / K 435 spool	55