TECHNICAL DATA SHEET

ER NiCrMo-10 (Alloy C22)   Nickel Alloy **TIG/GTAW**

Standards

EN/ISO-Standard - 18274
EN/ISO-Classification - Ni 6022 - NiCr21Mo13Fe4W3

AWS-Standard - A5.14
AWS-Classification - ER NiCrMo-10

Features and Applications

- Nickel-chromium-molybdenum alloy designed for joining C22, 625, 825 or combinations of these alloys.
- Provides a tough Nb-free weld metal for dissimilar welds in super austenitic and super duplex stainless steels.
- Offers excellent resistance against stress & corrosion cracking, pitting and crevice corrosion.
- Extensively used for overlays and cladding of lower alloy steels.
- Typically used in the welding of aggressively corrosive media in chemical processing plants, corrosion resistant overlays and in severe offshore and petrochemical environments etc.
- **Test Certificates can be found online @wilkinsonstar247.com**

Typical Base Materials

Alloy 22, Alloy 625, Alloy 825, Alloy 926*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

TIG DC (-)

Mechanical Properties

Tensile Strength (N/mm²)	Yield Strength (N/mm²)	Elongation (%)	Impact Strength (J)
≥690	-	-	-

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition of Weld Metal %

	C %	Mn %	Fe %	P %	S %	Si %	Cu %	Ni %	Co %	Cr %	Mo %	V %	W %
max	0.010	0.50	2.00	0.020	0.010	0.08	0.50	49.00	2.50	20.00	12.50	0.30	2.50
min			6.00							22.50	14.50		3.50

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
6011100599	1.60	1000	5	Cardboard Tube
6011100600	2.40	1000	5	Cardboard Tube
6011100601	3.20	1000	5	Cardboard Tube

Made in Switzerland

TIG

WELD STAR