

NCM-622	A CHEMICALLY BASIC FLUX COATED MMA ELECTRODE FOR WELDING CORROSION RESISTANT ALLOY				DATA SHEET NO. 93									
SPECIFICATION	AWS A5.11		BS EN ISO 14172											
CLASSIFICATION	ENiCrMo-10		E Ni 6022											
PRODUCT DESCRIPTION	<p>The chemically basic flux is extruded onto a high purity nickel chromium core wire. The flux contains the remaining alloying elements together with alloys for deoxidation and grain refinement.</p> <p>The blend of silicates used during electrode production ensure both coating strength and resistance to subsequent moisture absorption.</p>													
WELDING FEATURES OF THE ELECTRODE	<p>The electrode is suitable for use on both AC and DC+ and welds with great arc stability and thus control of the molten weld pool. Slag detachability is good.</p> <p>The weld beads are bright and evenly rippled with fillet welds slightly convex.</p> <p>Strike and re-strike should be made with the established back step technique.</p>													
APPLICATIONS AND MATERIALS TO BE WELDED	<p>For Welding the following alloys: A494 CX 2MW (cast) UNS No 6022 (often referred to as Alloy C22) ASTM UNS N06455</p> <p>Proprietary alloys include: HASTELLOY C22 and C4 (Haynes NiCroFer 5621h HW (VDM))</p> <p>May also be used for welding superaustenitics such as B66 (Uranus), 654SMo (Avesta) and these to NiCrMo alloys.</p>													
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Cu	Mo	V	W	Fe	Co	Ni
MIN		-	-	-	-	-	20	-	12.5	-	2.5	2.0	-	
MAX		0.02	1.0	0.2	0.015	0.03	22.5	0.5	14.5	0.35	3.5	6.0	2.5	
TYPICAL		0.01	0.6	0.2	0.01	0.02	21	0.2	13.5	0.1	3.0	4.0	1.0	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS									
	Tensile strength	N/mm ²	690	790										
	0.2% Proof stress	N/mm ²	-	560										
	Elongation on 4d	%	25	35										
	Reduction of Area (RA)	%	-	38										
	Impact energy -196 °C	J	-	45										
WELDING AMPERAGE DCEP	Ø (mm)	2.6		3.2		4.0								
MIN		60		90		130								
MAX		100		130		180								
OTHER DATA	Electrodes that have become damp should be re-dried at 180 °C for 1 hour.													
RELATED PRODUCTS	Please contact our Technical Department for detail.													

