

QuNi22

EN ISO 18274 Ni 6022; AWS A5.14 ERNiCrMo-10 ; DIN 1736: SG-NiCr22Mo14W ; (M.- No. 2.4635)

For high-corrosion-resistant build-up welding on low-alloyed steels.
Joint-welding of similar base materials.
Good corrosion-resistance to acetic acid or contaminated sulphuric acid.

Recommendation for

2.4602 or similar; ASTM, F574,B619,B622 and B626,
Incoloy825, Hastelloy C4, C22 and C-276

Rework

Material- typical treatment

Material analysis in %

C	Si	Mn	Cr	Mo	Fe	Ni	V	W	Cu	Co
<0,01	<0,1	<0,5	21,0	13,0	3,0	Rest	<0,2	3,0	<0,2	<2,5

(test certificates upon request.)

Standard / Mechanical Values

Inert gas	Argon	Values of the pure weld metal
Temperature	20°C	
Yield strength Re	N/mm ²	500
Tensile strength Rm	N/mm ²	740
Elongation A (Lo = 5do)	%	44
Hardness untreated	HV	220

Following standard:

Laser welding wires

Rod: 333 mm / 1.000 mm special lengths upon request

Spool: K80 / K125 / K250 / SH253 / MA125

The reported values were determined by the manufacturer and / or by a neutral Laboratory.
We cannot guarantee for the accuracy.