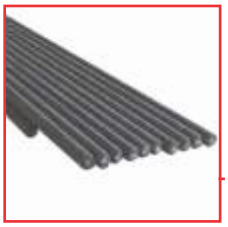

NICALLOY Mo-10

NON FERROUS (Ni Alloys)

Nickel base Electrode for C-22 material joining

CLASSIFICATION : ISO 14172	AWS A/SFA 5.11
E Ni 6022 (NiCr21Mo13W3)	E NiCrMo-10

KEY FEATURES :

- Basic coated non synthetic electrode
- Weld metal is of C-22 type
- Offers excellent corrosion resistance in oxidizing and reducing media
- Spectacular resistance to stress corrosion cracking, pitting and crevice corrosion
- Resistant to corrosion against acetic hydride, acetic and phosphoric acids, hot contaminated sulphuric and other contaminated oxidizing mineral acids
- Versatile product for the chemical, power, petroleum and marine industries

WELDING POSITION :

DCEP

TYPICAL APPLICATIONS :

- Joining materials of the same nature, e.g. material 2.4602 (NiCr21Mo14W) and these materials with low alloyed steels such as for surfacing on low alloy steels
- Welding components in chemical processes handling highly corrosive media
- Dissimilar joints between Ni-Cr-Mo alloys and stainless, carbon or low alloy steels
- Overlay cladding on carbon, low alloy and stainless steels
- Digesters and paper making equipment, Scrubbers for flue gas desulphurization

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Fe	S	P	Si	V
Specification	0.02 max	1.0 max	2.0 to 6.0	0.015 max	0.03 max	0.2 max	0.35 max
	Cu	**Co**	**Cr**	**Mo**	**W**	**Ni**	**Other**
Specification	0.50 max	2.5 max	20.0 to 22.5	12.5 to 14.5	2.5 to 3.5	Rem.	0.50 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	690 min	25 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	45 - 70	1	10	10
3.15 x 350	80 - 100	1	10	10
4.0 x 350	90 - 130	1	10	10