



# TIG NI22

Old reference: TIG Ni22

## Classification

AWS A5.14 : ERNiCrMo-10

ISO 18274 : S Ni6022 (NiCr21Mo13Fe4W3)

## Description & Applications

Nickel alloy with high content of Cr and Mo for GTAW, which gives it exceptional corrosion resistance. It is particularly recommended for welding of C-276, C-22, and other highly corrosion resistant Ni-alloys and special stainless steels.

**Main applications:** Works well in different environments, de-pollution (absorbers, chimneys), sea water and fertiliser, flue gas desulphurisation.

### Base materials

UNS	Alloy	DIN	Material N°
N06022	C-22	NiCr21Mo14W	2.4602
N10276	C-276	NiMo16Cr15W	2.4819
N06455	C-4	NiMo16Cr16Ti	2.4610
N06625	625	NiCr22Mo9Nb	2.4856
N08825	825	NiCr21Mo	2.4858
N08926	254SMo	X1NiCrMoCuN25 20 6	1.4529

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Mo	Cu	P	S	Fe	W	Co	V	Ni
Min				20.0	12.5				2.0	2.5			49.0
Max	0.010	0.08	0.50	22.5	14.5	0.50	0.020	0.010	6.0	3.5	2.5	0.3	
Type	0.010	0.05	0.10	21.4	13.2	0.07	0.010	0.008	3.0	3.0	1.1	0.01	>49.0

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	-	-	-	-
Max				
Type	480	740	42	+20°C 180

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 l/min Back shielding: I1 (Ar) / N1 (Nitrogen) : 3-6 l/min

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[www.fsh-welding.com](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)