



NICALLOY Mo-10

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENiCrMo-10

CLASSIFICATION:

ISO 14172

E Ni 6022 (NiCr21Mo13W3)

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

APPROVALS: CE

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


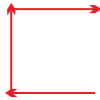
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

| C | Mn | Si | Fe | Ni | Cr | Mo | W |
|-------|-----|------|----|----|------|------|-----|
| 0.015 | 0.6 | 0.15 | 5 | 59 | 21.5 | 13.5 | 3.0 |

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 | | |
|------------|-------------|--|--|
| 2.5 x 350 | 45 - 70 |  AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr. | All Positions, except vertical Down  |
| 3.15 x 350 | 80 - 100 | | |
| 4.0 x 350 | 90 - 130 | | |

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.