ENiCrMo-10 Welding Electrode

For Alloys 622 / 625 and Alloy 25-6MO / 825

ENiCrMo-10 provides corrosion-resistant welds and protection against preferential weld metal attack when joining molybdenum-containing stainless steels, Alloy C-276, and Alloy 625. Its performance makes it suitable for demanding chemical and marine environments.

The electrode offers excellent operability for downhand groove and fillet welding, with smaller diameters suitable for all positions. Ideal for power, chemical, petroleum, and marine industry applications.

Specification

AWS A5.11 ENiCrMo-10 (UNS W86022)

ASME II, Part C, SFA-5.11, ENiCrMo-10 (UNS W86022)

ASME IX, F-No.43

*(EN) ISO 14172 – ENi6022 (NiCr21Mo13W3)

Custom specifications available upon request.

For information regarding certifications and industry approvals, please contact our Technical Department.

Limiting Chemical Composition

Element	Ni	C	Mn	Fe	P	S	Si
Content(%)	Remainder	0.02 max	1.0 max	2.0-6.0	0.03 max	0.75 max	0.50 max
Element	Cu	Co	Cr	Mo	V	W	Others
Content(%)	0.50 max	2.5 max	20.0-22.5	12.5-14.5	0.35 max	2.5-3.5	0.50 max

Minimum Mechanical Properties

Property	Value
Tensile Strength, psi	100,000
MPa	690
Elongation, (4d) %	25

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	229 12	356 14	356 14	356 14
Current (DC+)	A	50-70	75-100	80-140	125-150