

ERNiCrMo-10 Filler Metal

For Welding Alloys 22 / 625 and INCOLOY Alloys 25-6MO / 825

ERNiCrMo-10 filler metal is designed for gas-tungsten-arc (GTAW) and gas-metal-arc (GMAW) welding of nickel-chromium-molybdenum alloys such as Alloy 22, 625, and INCOLOY alloys 25-6MO and 825. It is also suitable for dissimilar welding, providing protection against preferential weld metal corrosion when joining molybdenum-containing stainless steels, Alloy C-276, and Alloy 625.

The weld metal's high chromium, tungsten, and molybdenum content ensures excellent resistance to pitting and crevice corrosion. ERNiCrMo-10 is versatile for dissimilar joints between nickel alloys, INCOLOY alloys, carbon steels, low-alloy steels, and stainless steels, and can be used with NT120 submerged-arc flux for welding and overlay applications.

Specification

AWS A5.14 ERNiCrMo-10 (UNS N06022)

ASME II, Part C, SFA-5.14, ERNiCrMo-10 (UNS N06022)

ASME IX, F-No.43

*(EN) ISO 18274 – SNi6022 (NiCr21Mo13Fe4W3)

Custom specifications available upon request.

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

Limiting Chemical Composition

Element	Nickel	C	Mn	Fe	P	S	Si
Content(%)	Remainder	0.015 max	0.50 max	2.0-6.0	0.02 max	0.01 max	0.08 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

Typical Mechanical Properties

Property	Value
Tensile Strength, psi	115,000
MPa	793
Elongation, (4d) %	40

Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)