

Exaton NiCrMo-10

NiCrMo-10 is a nickel-chrome-molybdenum alloy of type alloy C-22. It is a versatile alloy with excellent wet corrosion resistance in oxidizing and reducing media. It has better overall corrosion resistance than other Ni-Cr-Mo alloys such as alloy UNS N10276 (2.4819) and alloy UNS N06626 (2.4856). However, in severely reducing media alloy UNS N10276 is preferred where NiCrMo-4 is a better matching consumable. Applications for NiCrMo-10 are found in aggressively corrosive media such as chlorination systems, geothermal wells, HF furnace scrubbers, pesticide production, phosphoric acid production, SO cooling towers and for weld overlays on valves. NiCrMo-10 is used for joining alloy UNS N06022 (2.4602) and is widely used as overmatching filler material for alloy UNS N10276 (2.4819) and other nickel-chrome-molybdenum alloys for better weld metal properties. It is used for surfacing low alloyed steels.

Applications for NiCrMo-10 are found in components for organic synthesis, flue gas scrubber systems, electrolytic galvanizing, plate heat exchangers, phosphoric acid production, wet chlorine gas, hypochlorite and chlorine dioxide atmosphere. NiCrMo-10 is also used in combustion-resistant components for high pressure oxygen service and ferric and cupric chloride environments. It is used for MIG/MAG welding.

Classifications Wire Electrode	SFA/AWS A5.14 : ERNiCrMo-10 EN ISO 18274 : S Ni 6022 (NiCr21Mo13Fe4W3) Werkstoffnummer : 2.4602
Approvals	CE EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	150 J (111 ft-lb)
As Welded	-196 °C (-321 °F)	80 J (59 ft-lb)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Co
<=0.015	<=0.50	<=0.08	<=0.010	<=0.020	56	21.5	13.5	<=0.35	<=2.5

Typical Wire Composition %

Fe	W
<=4	3

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)