

GEMET 8022N

IDENTIFICATION

Gemet 8022, ENiCrMo-10

CLASSIFICATION

AWS/SFA 5.11: ENiCrMo - 10 (UNS. W 86022),
ISO 14172 - ENi6022 (NiCr21Mo 13 W3)

DESCRIPTION

Basic coated non-synthetic electrode manufactured using suitable Inconel wire for welding of Nickel-base alloys (alloy C-22) and other high corrosion resistant Ni-Cr-Mo and Ni-Cr-Mo-W alloys as well as special stainless steel types. Deposited welds are resistant in sulphurous acid environment, highly concentrated with chloride and highly oxidizing solution.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Fe	S	P	Cr	Mo	W	Co	V	Cu
0.02 max	1 max	0.2 max	2.0 - 6.0	0.015 max	0.03 max	20.0 - 22.50	12.5 - 14.5	2.5 - 3.5	2.5 max	0.35 max	0.5 max

ASME IX, F.NO.: 43

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (MPa)	EL (%) (L=4D)
700 min	450 min	25 min

TYPICAL APPLICATIONS

- Inconel alloy 622 and 625 Incoloy alloy 25-6 Mo and Incoloy 825.
- Excellent dissimilar welding electrode offering protection against preferential weld metal corrosion for joining molybdenum containing stainless steel Inconel alloys etc.
- Off-shore components, boilers, containers, piping systems in the chemical and petrochemical industries, power and marine industries.

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	50 - 70	2	2 x 5 = 10
3.15 / 3.20	350	70 - 100	2	2 x 5 = 10
4	350	80 - 140	2	2 x 5 = 10
5	350	130 - 160	2	2 x 5 = 10\