# 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.

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|---|---|
| **Classifications Wire Electrode** | SFA/AWS A5.14 : ERNiCrMo-10<br>EN ISO 18274 : S Ni 6022 (NiCr21Mo13Fe4W3)<br>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<br>(0.047 in.) | 150-260 A | 24-29 V | 3.0-10.0 m/min<br>(118-394 in./min) |



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