



S. R. Industries

STAR ARC ENiCrMo-10

Alloy C22 (ENiCrMo-10) electrodes are used for welding of nickel-chromium-molybdenum alloys as well as for overlay cladding on carbon, low alloy, or stainless steels. They are also used for dissimilar joints between nickel-chromium-molybdenum alloys and stainless, carbon, or low alloy steels. C22 offers excellent corrosion resistance in oxidizing as well as reducing media in a wide variety of chemical process environments. It also offers spectacular resistance to stress corrosion cracking, pitting, and crevice corrosion.

AWS Specification : A5.11/A5.11M:2010

AWS Classification		ENiCrMo-10		Welding Current				DCEP					
Typical Wire Chemistry													
C	Mn	Fe	P	S	Si	Cu	Nib	Co	Cr	Mo	V	W	Other
0.02	1.0	2.0-06	0.03	0.015	0.2	0.50	REM	2.5	20.0-22.5	12.5-14.5	0.35	2.5-3.5	0.50
Typical Mechanical Properties (As Welded)							Available Diameters and Operating Range in Amps						
Yield Strength, ksi		78		3/32"				65 -75					
Tensile Strength, ksi		114		1/8"				80 - 90					
Elongation%, min		36		5/32"				100 - 120					
Welding Positions		F,V,OH,H		3/16"				110 - 130					

b - includes incidental cobalt

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