

TASETO Welding Materials

Ni-Base Alloy Electrodes

For Flux Cored Arc Welding

GFWHsC-22

Applicable Specification
AWS A5.34 TNi6022-04

● Applications and Characteristics

TASETO GFWHsC-22 is used for welding of nickel alloy C-22 (UNS N06022) or overlay welding. Also used for welding of petrochemical and various chemical equipment that is required for the resistibility against oxidizing and reducing acid.

● Notes on Usage

* Only Ar+20%CO₂ is permitted for use as shielding gas.

* To minimize crater crack, fill craters with filler metal and remove crater crack with grinder.

● Chemical Composition of All Weld Metal(%)

	C	Mn	Fe	P	S	Si	Cu
Typical	0.018	0.34	5.46	0.008	0.002	0.18	0.04

	Ni	Co	Cr	Mo	V	W
Typical	Rem	0.81	21.44	12.95	0.23	3.11

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	515	717	30

● Corrosion Resistance of All Weld

(Corrosion loss: g/m²·h)

	1.5% hydrochloric acid (boiling)	30% sulfuric acid (boiling)	30% nitric acid (boiling)
Typical	0.42	0.091	0.032

● Sizes Available and Recommended Welding Conditions

Size (mm)	Flat			Horizontal		
	Current (A)	Voltage (V)	Speed (mm/min)	Current (A)	Voltage (V)	Speed (mm/min)
1.2	160~190	26~32	250~350	130~160	25~28	300~400