

Characteristics and field of use

The nickel-base metallic powder PLASweld™ NiBas6222Mo is designed for cladding similar corrosion- and temperature-resistant nickel-base alloys and for surfacing mild steels. PLASweld™ NiBas6222Mo can be used in chemical and petrochemical industries, for seawater-resistant surfacings as well as for repair purposes (valve cladding in ship engines).

PLASweld™ NiBas6222Mo yields a good creep strength, stress-corrosion-cracking and hot-cracking-resistance. The weld metal exhibits a high ductility at low temperature and a high strength up to 1100 °C and shows good corrosion-resistance to many media.

Typical analysis in wt%

C	Si	Cr	Mo	Nb	Fe	Ni
0.05	0.4	21.5	9.0	3.4	3.5	balance

Fe < 1%: available on request

Welding instruction

Preheating and interpass temperature should be adjusted to the base metal. To obtain the best weld metal properties, it is necessary to optimize the welding parameters of the laser or PTA process such as the main and pilot arc, plasma gas, welding speed and distance, weave width and powder flow.

Availability

-150 + 50 µm in 5 kg powder containers

Further packaging size and grain size ranges on demand.