

At Metals And Welding Specialities, we are proud to present the Xuper Nucleotec 2222 Welding Electrodes, a high-performance welding consumable engineered for the most demanding fabrication and repair tasks. This specialized electrode offers exceptional crack resistance, high ductility, and superb corrosion resistance across a wide temperature range. Designed for joining dissimilar materials and tackling challenging steel grades, the Xuper Nucleotec 2222 excels in applications where standard electrodes fall short.



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The Xuper Nucleotec 2222 electrode features a nickel-chromium-manganese alloy core, whose weld deposits resist grain boundary embrittlement and σ -phase formation, maintaining toughness at low temperature and stability under cyclic thermal loads. Its universal usability in all welding positions permits flexibility in layout and orientation. Under classification systems, it is identified under EN ISO 14172 as E Ni 6182, and under AWS standards corresponds to E NiCrFe-3 (sometimes referenced as an equivalent to CEWELD E NiCr 600). The material number (W. Nr.) for its nickel alloy formulation is 2.4807, and the equivalent UNS designation is UNS N06600 (or associated Ni-Cr-Fe classes)



Xuper Nucleotec 2222 Welding Electrodes, Xuper Nucleotec 2222 Welding Electrodes Manufacturers, Xuper Nucleotec 2222 Welding Electrodes Suppliers, Xuper Nucleotec 2222 Welding Electrodes Stockists, Xuper Nucleotec 2222 Welding Electrodes Exporters

In terms of mechanical performance, the Xuper Nucleotec 2222 deposit reliably achieves tensile strength in the 90,000–100,000 psi range (approximately 620–690 MPa) with elongation up to 45 % and excellent impact toughness even at subzero conditions. Because the weld metal matches its base in toughness and lacks harmful phases, it is ideal for critical structural joints, cryogenic equipment, heat exchanger assemblies, kiln tires, chemical plant components, and injection molds, where thermal cycling and stress concentration are frequent challenges

With its optimized alloy composition, **Xuper Nucleotec 2222** delivers excellent bonding characteristics on both carbon and alloy steels. Its weld deposits exhibit superior crack resistance, allowing for stress-free performance under thermal fatigue and shock loads. This makes it a preferred choice for critical components such as kiln tires, crusher rolls, exhaust manifolds, furnace parts, and rotary kilns. Each electrode is precision-manufactured to meet stringent quality standards, guaranteeing uniform deposition and predictable results for professional welders.



Xuper Nucleotec 2222 Welding Electrodes in India, Xuper Nucleotec 2222 Welding Electrodes Manufacturers in India, Xuper Nucleotec 2222 Welding Electrodes Suppliers in India, Xuper Nucleotec 2222 Welding Electrodes Stockists in India, Xuper Nucleotec 2222 Welding Electrodes Exporters in India

By choosing the Xuper Nucleotec 2222 electrode from Metals And Welding Specialities, clients gain the assurance of a premium nickel alloy welding solution, backed by material integrity, dimensional stability, and seamless performance under thermal cycling. Whether your project involves heavy section welds, repair of critical equipment, or dissimilar material joints, this electrode offers the durability, strength, and corrosion resistance your operations demand. Trust in this product to deliver X-ray quality welds, minimal distortion, and a weld metal that holds up where conventional electrodes cannot.

Specification Xuper Nucleotec 2222 Welding Electrodes



Parameter	Specification
Classification (DIN EN / EN ISO)	E Ni1 / Ni6182 (NiCr 15 Fe 6 Mn)
Material No.	2.4807
Tensile Strength (as deposited)	≈ 100,000 psi (≈ 690-700 MPa)
Yield Strength (as deposited)	≈ 61,600 psi (≈ 425 MPa)
Elongation (l = 5d)	≈ 45 %
Reduction of Area	≈ 53.2 %
Current Type	DC-Reverse polarity
Welding Positions	All positions except PG(f)

Available Diameters / Weights	Ø 2.5 mm / 2.5 kg, Ø 3.2 mm / 5 kg, Ø 4.0 mm / 5 kg, Ø 5.0 mm / 5 kg
Tensile Strength (alternate source)	~ 670 MPa (~ 97,000 psi)
Yield Strength (alternate source)	~ 390 MPa (~ 56,500 psi)
Impact Strength (ISO-V at 20 °C)	~ 130 J
Hardness (BHN)	~ 180 BHN

Xuper Nucleotec 2222 Welding Electrodes Parameters



Property	Value										
Tensile Strength	120,000 psi										
Yield Strength	79,000 psi										
Elongation (1 = 5d) min.	25 %										
Hardness (as-deposited)	90 HRB										
Maximum Service Temperature (steady state)	800 °F										
Electrode Current Polarity	DCEP (+) or AC (~)										
Diameter / Operating Current (amps)	<table border="1"> <thead> <tr> <th>Diameter</th> <th>Amperage Range</th> </tr> </thead> <tbody> <tr> <td>³/₃₂" (2.4 mm)</td> <td>55 – 70 A</td> </tr> <tr> <td>¹/₈" (3.2 mm)</td> <td>75 – 95 A</td> </tr> <tr> <td>⁵/₃₂" (4.0 mm)</td> <td>90 – 115 A</td> </tr> <tr> <td>³/₁₆" (4.8 mm)</td> <td>135 – 190 A</td> </tr> </tbody> </table>	Diameter	Amperage Range	³ / ₃₂ " (2.4 mm)	55 – 70 A	¹ / ₈ " (3.2 mm)	75 – 95 A	⁵ / ₃₂ " (4.0 mm)	90 – 115 A	³ / ₁₆ " (4.8 mm)	135 – 190 A
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People Also Searched

Xuper Nucleotec 2222 electrode, Nucleotec 2222 welding rod, E NiCrFe-3 electrode, UNS N06600 welding consumable, W. Nr 2.4807 electrode, Nickel-chromium coated electrode, Nickel alloy stick electrode, High nickel welding rod, Dissimilar metal join electrode, Cryogenic weld electrode, Nickel alloy repair rod, Heat exchanger weld electrode, Chemical plant weld consumable, Overlay electrode NiCrFe, Kiln tire weld rod, Tool steel weld electrode, Nickel steel weld electrode, Low temperature tough electrode, Corrosion resistant weld wire, High ductility weld rod, X-ray quality weld electrode, Welding electrode UNS N06600, ASTM Grade NiCrFe electrode, Nickel-based SMAW rod, Nickel alloy stick rod, Heavy section weld electrode, Thermal cycling weld consumable, Welding Ni to steel, Nickel inox weld rod, High strength weld electrode, Nickel repair electrode, Alloy 600 weld rod, Inconel weld rod alternative, Castolin Xuper Nucleotec, EutecTrode 2222 electrode, Nickel electrode all position, Nickel repair consumable.