

HASTELLOY® 622 RTW™ Filler Metal

Product Description:

HASTELLOY® 622 RTW™ filler metal is used for weld overlay applications and has an enriched chemistry for outstanding resistance to pitting, crevice corrosion and stress-corrosion cracking. It has excellent resistance to oxidizing aqueous media including wet chlorine. The weld metal has excellent resistance to preferential corrosive attack in various media and thus is a great candidate for overlay and cladding of carbon steels. The alloy makes a great candidate for dissimilar welding of other nickel-chromium-molybdenum alloys and stainless steels. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNiCrMo-10 UNS N06022

ASME-SFA-5.14 ERNiCrMo-10

Composition:

Nickel:	Balance	Other:	0.50 max.
Chromium:	22.1-22.5	Vanadium:	0.35 max.
Molybdenum:	14.0-14.5	Silicon:	0.08 max.
Tungsten:	3.25-3.5	Phosphorus:	0.02 max.
Cobalt:	2.50 max.	Carbon:	0.015 max.
Copper:	0.50 max.	Sulfur:	0.010 max.
Manganese:	0.50 max.		

Minimal Mechanical Properties:

Tensile Strength (psi)	115,000
Tensile Strength (MPa)	793
Elongation (%)	40

Available Product Forms and Sizes:

Diameter, in	0.030	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	*0.125	*0.156x	*0.187x
Diameter, mm	0.76	0.80	0.89	1.00	1.10	1.20	1.60	2.00	2.40	*3.20	*4.00x	*4.70x

Filler metals are available in MIG spools, TIG cut lengths, reels, and coils from the above diameters.

*Size not available in MIG spools.

ËSize not available on reels.

Standard TIG straight lengths are available in 36" (914mm) lengths.

Other lengths available upon request.