

Wire and Welding products

HAYNES
Wire Company



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
ASME-SFA-5.14 ERNiCrMo-10

Wire Chemistry:

Ni.....	Balance	Other.....	0.50 max.
Cr.....	22.1 - 22.5	V.....	0.35 max.
Mo.....	14.0 - 14.5	Si.....	0.08 max.
W.....	3.25 - 3.5	P.....	0.02 max.
Co.....	2.50 max.	C.....	0.02 max.
Cu.....	0.50 max.	S.....	0.010 max.
Mn.....	0.50 max.		

Minimum Mechanical Properties:

Tensile (psi)	115,000
Mpa	793
Elongation (%)	40

Available Product Forms:

Diameter in	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
Diameter mm	0.8	0.9	1.0	1.1	1.2	1.6	2.0	2.4	3.2

Filler metals are available in spools and in cut lengths from the above diameters.
Straight lengths are available in 36" lengths.

HW-7033

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