

# 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:

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

## Minimal Mechanical Properties:

<b>Tensile Strength (psi)</b>	115,000
<b>Tensile Strength (MPa)</b>	793
<b>Elongation (%)</b>	40

## Available Product Forms and Sizes:

<b>Diameter, in</b>	0.030	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	*0.125	*0.156x	*0.187x
<b>Diameter, mm</b>	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.

ËÿSize not available on reels.

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

*Other lengths available upon request.*