

TECHALLOY® 622

Nickel ■ AWS ERNiCrMo-10

KEY FEATURES

- Excellent corrosion resistance in oxidizing as well as reducing media in a wide variety of chemical process environments
- Outstanding resistance to stress corrosion cracking, pitting and crevice corrosion
- Q2 Lot® - Certificate showing actual deposit composition available online

WELDING POSITIONS

All

CONFORMANCES

AWS A5.14M: 2011
UNS

ERNiCrMo-10
N06022

TYPICAL APPLICATIONS

- A nickel based alloy with chromium, molybdenum, and tungsten as the principal alloying elements
- Used for cladding overlay as well as thermal spray applications

SHIELDING GAS

MIG 75% Ar / 25% He
TIG 100% Ar

DIAMETERS / PACKAGING

Diameter in (mm)	MIG 33 lb (15 kg) Steel Spool	TIG 10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton	SAW 55 lb (25 kg) Basket
0.035 (0.9)	MG622035667		
0.045 (1.1)	MG622045667		
1/16 (1.6)	MG622062667	TG622062638	
3/32 (2.4)		TG622093638	SA622093726
1/8 (3.2)		TG622125638	

WIRE COMPOSITION⁽¹⁾ - As Required per AWS A5.14M: 2011

	%C	%Mn	%Fe	%P	%S	%Si	%Cu
Requirements AWS ERNiCrMo-10	0.015 max	0.50 max	2.0 - 6.0	0.02 max	0.010 max	0.08 max	0.50 max
Typical Performance⁽²⁾ Techalloy® 622	0.01	0.14	4.4	0.003	0.002	0.07	0.01
	%Ni	%Co	%Cr	%Mo	%V	%W	%Other
Requirements AWS ERNiCrMo-10	Remainder	2.50 max	20.0 - 22.5	12.5 - 14.5	0.35 max	2.5 - 3.5	0.50 max
Typical Performance⁽²⁾ Techalloy® 622	56	0.1	21.4	13.8	0.02	3.1	<0.50

TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Gas
MIG	0.035 (0.9) 0.045 (1.1) 1/16 (1.6)	26-29 28-32 29-33	140-190 160-200 200-250	75% Argon / 25% Helium
SAW	3/32 (2.4)	28-30	275-350	Lincolnweld® P2000

⁽¹⁾Typical all weld metal. ⁽²⁾See test results disclaimer on pg. 13.
Safety Data Sheets (SDS) are available on our website at www.lincolnelectric.com