



DESCRIPTION

Executive 622 is a nickel-chromium-molybdenum alloy used for GTAW, GMAW, and SAW and used in the joining of ASTM B574, B575, B619, B622 and B628 having UNS Number N06022.

It can also be used for clad overlay as well as metal spray applications. Executive 622 offers excellent corrosion resistance in oxidizing as well as reducing media in a wide variety of chemical process environments. It offers an outstanding resistance to stress corrosion cracking, pitting, and crevice corrosion.

TYPICAL CHEMICAL VALUES

C	Mn	Fe	P	S	Si	W	Cr	Mo	Ni	TOE
0.008	0.20	3.1	0.005	0.002	0.04	3.5	21.5	13.5	Bal	<0.50

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.062	26 - 29	250 - 320	20 - 30 IPM (250 to 500mm)/min	Record NiCrW
	.093	28 - 31	300 - 350	20 - 30 IPM (500 to 750mm)/min	Record NiCrW
	.125	29 - 32	350 - 550	20 - 30 IPM (500 to 750mm)/min	Record NiCrW
GMAW	.035	26 - 29	150 - 190	30 to 50 CFH	75% Argon+25% Helium
	.045	28 - 32	180 - 220	30 to 50 CFH	or
	.062	29 - 33	210 - 250	30 to 50 CFH	50% Argon + 50% Helium
GTAW	.093	15 - 20	120 - 175	30 to 40 CFH	100% Argon

MECHANICAL PROPERTIES

Tensile Strength: 100,000 PSI minimum 690 MPA
Yield Strength: 82,000 PSI 570 MPA
Elongation: 38%

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.14, Class ERNiCrMo-10** ISO 18274, Class SNi 6022.