

DESCRIPTION

Executive 622 is a nickel-chromium-molybdenum alloy designed for welding alloys 22, 625 and 825 using TIG, MIG and SAW welding processes. This alloy is also used for many dissimilar Inconel® alloy joints and weld overlay. The high alloy content of Executive 622 produces high strength weld material with excellent pitting and crevice corrosion resistance.

Executive 622 filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver the results fabricators demand.

APPLICATIONS & FEATURES

Executive 622 is a versatile filler metal that is used to weld dissimilar joints between nickel-chrome-molybdenum alloys and molybdenum bearing stainless steels as well as carbon or low alloy steels.

Executive 622 is used extensively for overlay applications where resistance to pitting and crevice corrosion is required.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	Co	V	Cr	W	Mo
0.006	0.23	2.40	0.003	0.001	0.05	0.02	56.40	0.01	0.01	22.30	3.36	14.40

Tensile Strength: 115,000 PSI Min **Yield Strength:** **Elongation:** 40%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	17-20	70-90	30 to 50 CFH	100% Ar	
	.045"	19-22	75-160		75% Ar / 25% He	
	- Spray	.045"	30-32		190-250	90% He / 7.5% Ar / 2.5% CO ₂
	- Pulse	.045"	18-20		120-150	
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.062"	28-32	250-280		NiCr-W Flux	
	.093"	28-33	275-350			
	.125"	29-34	350-450			

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	500-lb Drum
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	
	60-lb Acro Pak	



CLASSIFICATION

AWS/SFA 5.14, Class **ERNiCrMo-10**