

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

HAYNES
Wire Company

158 N. Egerton Road P.O. Box 677 Mountain Home, North Carolina USA 28758-0677
Telephone: 828-692-5791 800-438-7263 FAX: 828-697-9818 haynesintl.com

HASTELLOY® 622 RTW™ Filler Metal