



INCONEL[®] Filler Metal 622

INCONEL Filler Metal 622 is used for gas-tungsten-arc and gas-metal-arc welding of INCONEL alloys 22 and 625, INCOLOY alloy 25-6MO, and INCOLOY alloy 825. This is also an excellent dissimilar metal welding product that offers protection against preferential weld metal corrosion when used for joining molybdenum-containing stainless steels, INCONEL alloy C-276, and INCONEL alloy 625. The high chromium content, along with the tungsten and molybdenum, give good resistance to pitting and crevice corrosion. INCONEL Filler Metal 622 is useful for many dissimilar joints involving INCONEL and INCOLOY alloys, and carbon, low-alloy and stainless steels. Submerged arc welding and overlaying can be done with INCOFLUX NT120 Submerged Arc Flux.

Specifications

AWS A5.14 ERNiCrMo-10 (UNS N06022)

ASME II, Part C, SFA-5.14, ERNiCrMo-10 (UNS N06022)

ASME IX, F-No.43

*(EN) ISO 18274 - SNi6022 (NiCr21Mo13Fe4W3)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), and other specifications

please refer your inquiry to the Technical Department prior to order placement.

Approvals

VdTUV - 926/032088

Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

| | | | |
|--------------|------------|--------------|-----------|
| Nickel | Remainder | Cu | 0.50 max. |
| C | 0.015 max. | Co | 2.5 max. |
| Mn | 0.50 max. | Cr | 20.0-22.5 |
| Fe | 2.0-6.0 | Mo | 12.5-14.5 |
| P | 0.02 max. | V | 0.35 max. |
| S | 0.01 max. | W | 2.5-3.5 |
| Si | 0.08 max. | Others | 0.50 max. |

Typical Mechanical Properties

| | |
|-----------------------|---------|
| Tensile Strength, psi | 115,000 |
| MPa | 793 |
| Elongation, (4d) % | 40 |

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

| mm | 0.8 | 0.9 | 1.0 | 1.14 | 1.2 | 1.6 | 2.4 | 3.2 |
|----|-------|-------|-------|-------|-------|-------|-------|-------|
| in | 0.030 | 0.035 | 0.040 | 0.045 | 0.047 | 0.062 | 0.093 | 0.125 |

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)