



622T-1 (ENiCrMo10T1-4)

SPECIFICATION: AWS A5.28 /ASME SFA5.34 Class ENiCrMo10T1-4

DESCRIPTION: 622T-1 is an all position, gas-shielded, flux cored, nickel-based electrode. It is used to join NiCrMo to itself and other nickel based alloys, for surfacing steel and joining nickel to steel. 622T-1 is designed to weld in marine and off shore environments as well as chemical, power generation, petroleum and corrosion resistant applications.

RECOMMENDED SHIELDING GAS: 75% Ar/25% CO₂.

AVAILABLE SIZES: .045" x 25 lb. spools.

TYPICAL DEPOSIT CHEMISTRY:

C	Mn	Si	Cr	Ni	Mo	Fe	W
0.02	.40	.20	21.4	Bal	13.8	5.2	3.3

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	106,000 psi
Yield Strength	67,000 psi
Elongation	30%

RECOMMENDED WELDING PARAMETERS:

Position	Amps	Volts	WPS
Flat	180	27-28	400
Overhead	140	26	300
Vertical up	140	26	300

(1/2 - 5/8" contact tip to work distance)

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

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