

## GEN 622 Welding Wire and Rod

GEN 622 is used for MIG, TIG and SAW for nickel-chromium-molybdenum alloys such as 601, 690, 800 and 825. It may also be used for cladding and welding dissimilar base metals such as Ni-Cr-Mo alloys to stainless, carbon and low alloy steels. The high chromium and molybdenum contents provide good resistance to crevice and pitting corrosion.

### CONFORMANCES

AWS A5.14 : ERNiCrMo-10  
 ASME SFA-5.14 : ERNiCrMo-10  
 ISO 18275 : SNI 6022

### AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%W	%Fe	%Mn
0.015 max	20.0 – 22.5	rem.	12.5 – 14.5	2.5 – 3.5	2.0 – 6.0	0.50 max
0.005	22.2	56.1	14	3.1	3.9	0.25
%Si	%P	%S	%Cu	%Co	%V	Total Others
0.08 max	0.02 max	0.010 max	0.50 max	2.5 max	0.35 max	0.50 max
0.05	0.003	0.001	0.01	0.05	0.03	

### TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength : 80,000 psi  
 Tensile Strength : 115,000 psi  
 Elongation : 36 %

### TYPICAL WELDING PARAMETERS\*

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 19	90 – 130	100% Ar
	3/32"	2.4 mm	15 – 20	120 – 175	100% Ar
	1/8"	3.2 mm	15 – 20	150 – 225	100% Ar
MIG (GMAW)	.035"	0.9 mm	26 – 30	150 – 200	75% Ar – 25% He
	.045"	1.1 mm	28 – 32	170 – 220	75% Ar – 25% He
Sub Arc (SAW)	.093"	2.4 mm	28 – 30	280 – 350	
	.125"	3.2 mm	29 – 32	400 – 550	

\*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<b>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</b> BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.
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