

MIDALLOY ERNiCrMo-10 (FM622) BARE WIRE

CLASSIFICATION

- AWS 5.14 Class ERNiCrMo-10 / ASME SFA 5.14 Class ERNiCrMo-10

DESCRIPTION

- MIDALLOY ERNiCrMo-10 nickel alloy bare wire is used for GMAW, GTAW, and SAW welding.

APPLICATIONS

- MIDALLOY ERNiCrMo-10 nickel alloy bare wire is used to weld alloys of similar composition, as well as dissimilar materials such as nickel-chromium-molybdenum alloys to stainless steel or low alloy steels.
- Because of its excellent corrosion resistance in oxidizing as well as reducing media, and its outstanding resistance to stress corrosion cracking, pitting, and crevice corrosion, this alloy is often chosen for cladding.

TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu
.005	.20	2.60	.007	.001	.06	.09
Ni	Cr	Mo	V	W	Co	
Balance	20.25	14.13	.03	3.01	.06	

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	114,000 PSI
YIELD STRENGTH	82,000 PSI
ELONGATION	38%

RECOMMENDED WELDING PARAMETERS

(See attached)

STANDARD PACKAGING

- TIG 10 lb. tube / 60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

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