



## Unibraze 622

**CLASSIFICATIONS:** AWS A5.14/ASME SFA 5.14 Class ERNiCrMo-10 UNS N06622

**DESCRIPTION:** Unibraze 622 is a bare nickel alloy with Cr, Mo and W added as principal alloying elements. It is used for GTAW, GMAW and SAW welding of similar alloys as well as dissimilar joints between Ni-Cr-Mo alloys and stainless, carbon and low alloy steels. Unibraze 622 has excellent resistance to pitting and crevice corrosion.

### TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Co	V	W	Others
.015 max	20.0- 22.5	Bal	12.5- 14.5	.50 max	.08 max	.02 max	.010 max	2.0- 6.0	.50 max	2.5 max	.35 max	2.5 - 3.5	.50 max

### TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	115,000 psi (790 MPa)
Yield Strength	82,000 psi (570 MPa)
Elongation	38%

### TYPICAL WELDING PARAMETERS:

	Diameter	Voltage	Amperage	Shielding Gas
MIG	.035" (.9mm)	26-29	150/190	75% Ar/25% He
	.045" (1.14mm)	28-32	180/220	
	.062" (1.6mm)	29-33	200/250	
TIG	.035" (.9mm)	12-15	60-90	100% Ar
	.045" (1.14mm)	13-16	80-110	
	1/16" (1.6mm)	14-18	90-130	
	3/32" (2.4mm)	15-20	120-175	
	1/8" (3.2mm)	15-20	150-220	
SAW	3/32" (2.4mm)	28-30	275-350	Suitable Flux
	1/8" (3.2mm)	29-32	350-450	
	5/32" (4.0mm)	30-33	400-550	

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.