



UNIBRAZE 622T-1

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

Description: Unibrazed 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. Unibrazed 622T-1 is designed to weld in marine and off shore environments as well as chemical, power generation, petroleum and corrosion resistant applications.

Shielding Gases: 100% CO₂, 75/80% Ar/ CO₂ balance, 40-55 cfh

Typical Deposit Chemistry (75% Ar/25% CO₂)

C	Mn	Si	Cr	Ni	Mo	Fe	W
.02	.40	.20	21.4	Bal	13.8	5.2	3.3

Typical Mechanical Properties (75% Ar/25% CO₂)

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

Optimum Welding Parameters (75% Ar/25% CO₂)

Diameter	Position	Amps	Volts	WPS
.045"	Flat	190	27	400
	Overhead	140	26	300
	Vertical up	140	26	300
1/16"	Flat	200	26	225
	Overhead	175	24	175
	Vertical Up	175	24	175

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

*For CO₂ shielding gas increase voltage by 1/2 – 1 volt.