

## DESCRIPTION

Executive 622 AP FC is a nickel-chromium-molybdenum gas shielded FCAW wire that can be used for welding in all positions using 100% CO<sub>2</sub> or Argon/ CO<sub>2</sub> mixtures. It is the flux cored equivalent to Executive 622 and has a complimentary chemistry to Alloy 622, yet provides the ease of welding and increased deposition rates associated with flux cored wire.

The high chromium content along with the molybdenum of Executive 622 AP FC results in good resistance to pitting and crevice corrosion.

## APPLICATIONS & FEATURES

Executive 622 AP FC possess excellent weldability and can be used for the joining of ASTM B574, B575, B619, B622, and B628 having UNS number N06022.

It can also be used in a wide variety of dissimilar welding applications including surfacing steel with nickel-chromium-molybdenum weld metal and cladding the side of joints in steels clad with nickel-chromium-molybdenum weld metal and even with high nitrogen containing stainless steels.

## TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	V	W	Cr	Co	Mo	TOE
0.02	0.42	5.1	0.01	<0.001	0.14	0.04	56.21	0.12	3.0	20.9	0.13	13.7	0.15
<b>Tensile Strength:</b>		103,000 PSI min				<b>Yield Strength:</b> 70,000 PSI min				<b>Elongation:</b>		27%	

## TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	Wire Feed Speed (in./min)	Stick-Out	Shielding Gas
.045"	25-26	140-210	290-400 IPM	1/2"	100% CO <sub>2</sub> or 75% Ar / 25% CO <sub>2</sub>
.062"	26-27	180-260	190-275 IPM	1/2"	100% CO <sub>2</sub> or 75% Ar / 25% CO <sub>2</sub>

## STANDARD PACKAGING

**Spools** 33-lb wire baskets

## CLASSIFICATION

AWS/SFA A5.34, Class **ENiCrMo10T1-1/4**

