

# RODA ALLOY 622



 **Rodacciai**  
SINCE 1956 ALL OVER THE WORLD



## DESCRIPTION AND APPLICATIONS

Roda Alloy 622 is a Ni-Cr-Mo alloy consumable, used for GTAW, GMAW of Ni-Cr-Mo alloys (i.e. UNS N06022, UNS N08825, UNS N06625, UNS N10276). It is suitable for dissimilar welding of Ni-Cr-Mo alloys with Ni-Cr-Mo austenitic stainless steels. The presence of chromium, molybdenum and tungsten increases pitting and crevice corrosion resistance. It can be used also for surfacing of carbon and low alloy steels.

## APPROXIMATE EQUIVALENT WITH OTHER STANDARDS

Rodacciai Denomination	Rodaalloy 622
EN ISO 18274:2010	Ni 6022 - NiCr21Mo13Fe4W3
AWS A5.14/A5.14M: 2018	ERNiCrMo-10 - N06022
DIN Werkstoff Nr.	2.4635

## FILLER METAL PROPERTIES

Typical Chemical composition (nominal) in %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	W	V	Co	Fe
≤0,015	≤0,25	0,05	≤0,005	0,005	22	56	14	≤0,08	3	0,10	0,05	≤5

## EXPECTED MINIMUM MECHANICAL PROPERTIES AS WELDED

Temperature		20°C	-196°C
Yield strength, Rp 0,2	MPa min	480	
Tensile strength, Rm	MPa min	750	
Elongation, A5	% min	35	

## TYPICAL WELDING PARAMETERS

Process	Diameter		Volt	Ampere	Gas
	mm	inches			
MIG	1,0	0.035	26-29	140-190	75% Ar + 25% He
	1,2	0.045	28-32	160-200	75% Ar + 25% He
	1,6	1/16	29-33	200-250	75% Ar + 25% He
TIG	3,2	1/8	25-30	275-350	100% Ar

Welding positions down hand, horizontal/vertical, vertical upward, overhead.  
Highest operating temperature, in the short term range, as for base metal, but not

higher than 1000 °C. Lowest operating temperature, as for base metal, but not lower than -196°C

## SIZES AND MARKING

Standard sizes : diam. mm 0,80 – 0,90 – 1,00 – 1,14 – 1,20 – 1,60 – 2,00 – 2,40 – 3,20 – 4,00  
diam. inches 0.030 – 0.035 – 0.045 – 1/16 – 3/32 – 1/8 – 5/32

## PACKAGING FORMS

TIG - White carton boxes of 5 kg / 10 Lb. Red, white or blue coloured cardboard tubes of 5 kg / 10 Lb. Wooden crates of 250 kg / 660 Lb.

MIG - Blue metallic wire baskets BS300 of 15 kg / 33 Lb. Plastic spools D300 of 12,5 kg / 25 Lb for diam. 0,80 mm and of 15 kg / 33 Lb for the other diameters.  
Plastic spools D200 of 5 kg / 10 Lb.

