

DESCRIPTION

Stoody 622-T1 is a gas shielded **All Position Flux Cored Wire** that results in a deposit that is within the chemical composition requirements of AWS 5.11, Class ENiCrMo-10, coated electrodes.. (Presently there is no AWS Class for flux cored types in this alloy group).

TYPICAL DEPOSIT CHARACTERISTICS

Tensile Strength	103 ksi (685 MPa)
Yield Strength	70 ksi (470 MPa)
Elongation	27%

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	0.02
Manganese	0.5
Silicon	0.2
Chromium	21.3
Molybdenum	13.8
Iron	5.0
Tungsten	3.1
Sulfur	0.001
Phosphorus	0.010
Nickel	Balance

TYPICAL APPLICATIONS

Typical applications include:

- Joining nickel-chromium-molybdenum alloys
- Clad side of joints in steels clad with nickel-chromium-molybdenum weld metal
- Surfacing steel with nickel-chromium-molybdenum weld metal
- Joining high molybdenum – high nitrogen containing stainless steels

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, in. (mm)	.045 (1.2)
Amperage (DCEP)	150 – 200
Wire Feed Speed (ipm)	290 – 400
Voltage	25 – 26
Shielding Gas	75% Ar -25% Co ₂ or 100%CO ₂
Wire Extension, in (mm)	1/2 (12)

Diameter, in. (mm)	1/16 (1.6)
Amperage (DCEP)	200 – 250
Wire Feed Speed (ipm)	190 – 275
Voltage	26 – 27
Shielding Gas	75% Ar -25% Co ₂ or 100% CO ₂
Wire Extension, in (mm)	1/2 (12)

STANDARD SIZES & PACKAGING

Diameter	Packaging	
.045" (1.2mm)	33# wire basket, LLW	11953800
1/16" (1.6mm)	33# wire basket, LLW	

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