

# SMT-22

## Conformances

AWS A5.14/ ASME SFA5.14 ERNiCrMo-10  
 JIS Z 3324 S Ni6022 (NiCr21Mo13Fe4W3)  
 EN ISO 18274 S Ni 6022

## Applications

- FGD, Petrochemical plants Offshore applications
- Inconel 625+601, Hastalloy C-22, Ni alloy steel

## Features

- Good resistance to pitting and crevice corrosion

## Welding Position

### Current

GMAW: DC+(Pulse)  
 GTAW: DC-

### Shielding Gas

Ar, Ar + He

### Diameter / Packaging

Diameter	MIG	TIG
mm (in)	12.5kg (27.6lbs)	5kg (11lbs)
1.0 (0.040)	✓	
1.2 (0.045)	✓	
2.0 (5/64)		✓
2.4 (3/32)		✓
3.2 (1/8)		✓

## Typical Chemical Composition of the Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo	W	Fe
0.01	0.06	0.38	0.001	0.001	22.4	55.5	14.2	2.8	4.1

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
-	720 (104,000)	41.0	-196 (-321)	110 (81)

## Typical Welding Parameters

Diameter, Polarity Shielding Gas	Amp. (A)	Volt. (V)
	1.2mm (0.045 in) DC+	
Ar, Ar + He	160	28
	2.4mm (3/32 in) DC-	
Ar	110	12