

Classifications

AWS A5.11 / SFA-5.11

EN ISO 14172

ENiCrMo-10 (mod.)

EZ Ni 6022 (NiCr21Mo13W3)

Characteristics and typical fields of application

UTP 722 Kb is suited for joining materials of the same nature, as e.g. material-no. 2.4602 (NiCr21Mo14W), for joining these materials with low-alloyed steels or for cladding on low-alloyed steels.

Another application field is welding of components in chemical plants which are exposed to highly corrosive media. UTP 722 Kb provides good corrosion resistance against acetic acid and acetic hydride, hot contaminated sulphuric and phosphoric acids and other contaminated oxidising mineral acids.


Typical analysis

	C	Si	Mn	Cr	Ni	Mo	W	Fe
wt.-%	< 0.02	< 0.2	0.8	21.0	bal.	13.5	3.0	3.0

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J
	MPa	MPa	%	
u	> 450	> 720	> 30	> 70

Operating data

	Polarity	DC +	Dimension mm	Current A	
				2.5 × 250	50 – 70
				3.2 × 300	70 – 110

Welding instructions

UTP 722 Kb can be welded in all positions except vertical-down. It shows a stable arc and very easy slag removal. Opening angle of the prepared seam approx. 70°, root gap approx. 2 mm. Weld stick electrode with slight tilt and a short arc, doing string beads. An interpass temperature of 150°C and a max. weaving width of 2.5 x diameter of the stick electrode core wire should not be exceeded. Re-dry the stick electrodes 2-3 hours at 250-300°C prior to use and weld them out of a warm stick electrode holder.

Approvals

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