Thermanit MTS 616

SAW wire, low-alloyed, creep resistant

Classifications

EN ISO 24598-A	AWS A5.23 / SFA-5.23
S S ZCrMoWVNb 9 0,5 1,5	EG (EB91(mod.))

Characteristics and typical fields of application

Thermanit MTS 616 is a solid wire for submerged arc welding; High temperature resistant. Suited for joining and surfacing applications with matching high temperature resistant parent metal P92 according to ASTM A 335.

Recommended SAW flux:
Record 543

Base materials

1.4901 – X10CrWMoVNb9-2; NF 616;
ASTM A 355 Gr. P92

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	W	V	Nb	N
wt.-%	0.11	0.15	0.5	8.8	0.45	0.45	1.65	0.20	0.06	0.04

Structure: Martensite, suitable for quenching and tempering

Operating data

Dimension mm
1.2
1.6
2.0
2.5
3.0
3.2
4.0

Tempering at 760ºC min. 2 h, max 10 h / cooling down to 300ºC in oven; air heating / cooling rate below 550ºC max. 150ºC/h, above 550ºC max. 80ºC/h. When tempering below 2 h the requirements need to be verified by a WPQR. Preheat and interpass temperature 200 - 300ºC. Cool down to 100ºC before post-weld heat treatment.
Polarity: DC-
Shielding gas: 100% Ar. Gas flow: 4 – 8 l/min.

Approvals

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All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.