UTP UP 6222 Mo

SAW solid wire

Classifications		
EN ISO 18274	AWS A5.14	Material-No.
S Ni 6625 (NiCr22Mo9Nb)	ER NiCrMo-3	2.4831

Characteristics and field of use

UTP UP 6222 Mo is applied for joint welding of base materials with the same or with a similar composition, e. g. Alloy 625 (UNS N06625) or NiCr22Mo9Nb, Material-No. 2.4856 or mixed combinations with stainless steels and carbon steels. Furthermore the wire is used for cold-tough Ni-steels, e. g. X8Ni9 for LNG projects. UTP UP 6222 Mo is also applied on alloyed or unalloyed steels for cladding of corrosion resistant plants.

Typical analysis in %

C	Si	Cr	Mo	Ni	Nb	Fe
< 0,02	< 0,2	21,0	9,0	balance	3,3	2,0

Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V	
MPa	MPa	%	J [RT]	– 196 °C
460	725	40	> 80	65

Welding instruction

The welding area has to be free from impurities (oil, paint, markings etc.). Welding must be performed with a low heat input. The maximum interpass temperature is at 150 °C.
Stick out: approx. 25 mm

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Travel Speed [cm/min]
1,6	200-250	28-30	30-50
2,0	250-350	28-30	30-50
2,4	350-450	28-30	30-50
3,2	400-450	28-30	30-50