

## Classifications

Gas-shielded flux-cored wire

EN ISO 12153

AWS A 5.34

Material-No.

T Ni 6625 PM 2

ENiCrMo3 T1-4

2.4621

## Characteristics and field of use

The nickel-base-flux-cored wire (NiCrMo) UTP AF 6222 Mo PW is suitable for joining and surfacing on nickel-base materials of the same nature and on C- and CrNi steels as well as for cladding on C-steels, furthermore in high temperature applications.

2.4856	NiCr22Mo9Nb	N 06625	Alloy 625
1.4539	X NiCrMoCu25 20 5	N 08904	Alloy 904
1.4583	X NiCrNb18		
1.0562	12StE 355		
1.5662	X 8Ni9	ASTM A553	Typ 1

UTP AF 6222 Mo PW distinguishes by a hot cracking resistant and tough weld metal. It is suitable for operating temperatures up to 500 °C and above 800 °C. It must be noted that a slight decrease in ductility will occur if prolonged heat treatment is given within the temperature range 550 – 800 °C.

UTP AF 6222 Mo PW provides excellent positional welding. It has excellent welding properties with a regular and fine drop transfer. The weld seam is finely rippled and the transition from weld to base materials is regular and notch-free. The wide parameter range enables an application on different wall thicknesses.

## Typical analysis in %

C	Si	Mn	P	S	Cr	Mo	Ni	Nb	Fe
0.03	0.4	0.4	0.01	0.01	21.5	9.0	balance	3.5	0.5

## Mechanical properties of the weld metal

Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation $A$	Impact toughness $K_V$	
MPa	MPa	%	J [RT]	- 196 °C
490	750	30	70	60

## Welding instructions

Clean welding area cautiously, slightly trailing torch position.

## Welding positions



Current type DC (+)  
Shielding gas: M 21

## Approvals

TÜV (No.10991)

## Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage	Voltage [V]
1.2	170 – 200	26 – 32