

**UTP UP 068 HH**

anti-corrosion

**Classifications**

SAW solid wire

EN ISO 18274	AWS A5.14	Material-No.
S Ni 6082 (NiCr20Mn3Nb)	ER NiCr-3	2.4806

**Characteristics and field of use**

UTP UP 068 HH is used for claddings in the reactor construction and for joining of similar base metals and low-alloyed steels with stainless steels:

Mat-No.	DIN	UNS-No.
2.4816	NiCr15Fe	UNS N06600
2.4817	LC-NiCr15Fe	UNS N10665
1.4876	X 10NiCrAlTi 32 20	UNS N08800

**Typical analysis in %**

C	Si	Mn	Cr	Ni	Nb	Fe
< 0.02	< 0.2	3.0	20.0	balance	2.7	0.8

**Mechanical properties of the weld metal according to EN ISO 15792-1 (min. values at RT)**

<i>Yield strength <math>R_{p0.2}</math></i>	<i>Tensile strength <math>R_m</math></i>	<i>Elongation <math>A</math></i>	<i>Impact strength <math>K_V</math></i>
<i>MPa</i>	<i>MPa</i>	<i>%</i>	<i>J (RT)</i>
> 350	> 600	> 35	> 100

**Form of delivery and recommended welding parameters**

<i>Wire diameter [mm]</i>	<i>Amperage [A]</i>	<i>Voltage [V]</i>	<i>Travel Speed [cm/min]</i>
1.6	200 – 250	28 – 30	30 – 50
2.0	250 – 350	28 – 30	30 – 50
2.4	350 – 450	28 – 30	30 – 50