UTP UP 6222 Mo anti-corrosion

Classifications		SAW solid wire
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	1.0

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

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 instructions

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. Flux should be redried for approximately 2 hours at 300 – 400 °C prior to use.

Form of delivery and 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