UTP A 6808 Mo

stainless steels

Classifications		TIG rod
EN ISO 14343-A	AWS A5.9	Material-No.
W 22 9 3 N L	ER 2209	~ 1.4462

Characteristics and field of use

UTP A 6808 Mo is used for joining and surfacing of corrosion resistant steels as well as cast steel with austenitic-ferritic structure (Duplex steel). Working temperature: up to 250 °C

The weld deposit of UTP A 6808 Mo has an excellence resistance against pitting and stress corrosion cracking next to high strength- and toughness-properties. Very good weld- and flow characteristics.

Base materials

1.4462	X2 CrNiMoN 22-5-3	
1.4362	X2 CrNiN 23-4	
1.4462	X2 CrNiMoN 22-5-3 with	1.4583 X10 CrNiMoNb 18-12
1.4462	X2 CrNiMoN 22-5-3 with	P2356H / P265GH / S255H / P2956H / S35N / 16Mo3 UNS S31803; S32205

Typical analysis in %

C	Si	Mn	Cr	Mo	Ni	N	Fe
0.015	0.35	1.5	22.8	3.0	9.0	0.14	balance

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]*
600	800	30	80

Welding instructions

Welding area must be thoroughly cleaned to metallic bright and degreased. Preheating and post heat treatment are usually not necessary. The interpass temperature should not exceed 150 °C.

Approvals

TÜV (No. 05550), GL

Form of delivery and recommended welding parameters

Rod diameter x length [mm]	*Current type*	*Shielding gas (EN ISO 14175)*
1.6 x 1000	DC (–)	I 1
2.0 x 1000	DC (–)	I 1
2.4 x 1000	DC (–)	I 1
3.2 x 1000	DC (–)	I 1