

# UTP A 776

## Classifications

TIG rod

EN ISO 18274	AWS A5.14	Material-No.
S Ni 6276 (NiCr15Mo16Fe6W4)	ER NiCrMo-4	2.4886

## Characteristics and field of use

UTP A 776 is suitable for joint welding of matching base materials, as 2.4819 NiMo16Cr15W UNS N10276 and surface weldings on low-alloyed steels.

UTP A 776 is employed primarily for welding components in plants for chemical processes with highly corrosive media, but also for surfacing press tools, punches, etc. which operate at high temperature.

Excellent resistance against sulphuric acids at high chloride concentrations.

## Typical analysis in %

C	Si	Cr	Mo	Ni	V	W	Fe
< 0.01	0.07	16.0	16.0	balance	0.2	3.5	6.0

## Mechanical properties of the weld metal

<i>Yield strength <math>R_{p0.2}</math></i>	<i>Tensile strength <math>R_m</math></i>	<i>Elongation A</i>	<i>Impact strength <math>K_V</math></i>
<i>MPa</i>	<i>MPa</i>	<i>%</i>	<i>J [RT]</i>
> 450	> 750	> 30	> 90

## Welding instructions

To avoid intermetallic precipitations, the rod should be welded with lowest possible heat input and interpass temperature.

## Approvals

TÜV (No. 05587)

## Form of delivery and recommended welding parameters

<i>Rod diameter x length [mm]</i>	<i>Current type</i>	<i>Shielding gas (EN ISO 14175)</i>
1.6 x 1000	DC ( - )	R 1
2.0 x 1000	DC ( - )	R 1
2.4 x 1000	DC ( - )	R 1
3.2 x 1000	DC ( - )	R 1