

## Classifications

EN ISO 14172	AWS A5.11	Material-No.
E Ni 6625 (NiCr22Mo9Nb)	E NiCrMo-3	2.4621

## Characteristics and field of use

UTP 6222 Mo is particularly suited for joining and surfacing on nickel alloys, austenitic steels, low temperature nickel steels, austenitic-ferritic-joints and claddings of the same or similar nature, like 2.4856 (NiCr22Mo 9 Nb), 1.4876 (X30 NiCrAlTi 32 20), 1.4529 (X2 NiCrMoCu 25 20 5).

The weld metal is heat resistant and suitable for operating temperatures up to 1000° C. It must be noted that a slight decrease in ductility will occur if prolonged heat treatment is given within the temperature range 600 - 800° C. Scale-resisting in low-sulphur atmosphere up to 1100° C. High creep strength.

## Typical analysis in %

C	Si	Mn	Cr	Mo	Ni	Nb	Fe
0,03	0,4	0,6	22,0	9,0	balance	3,3	< 1

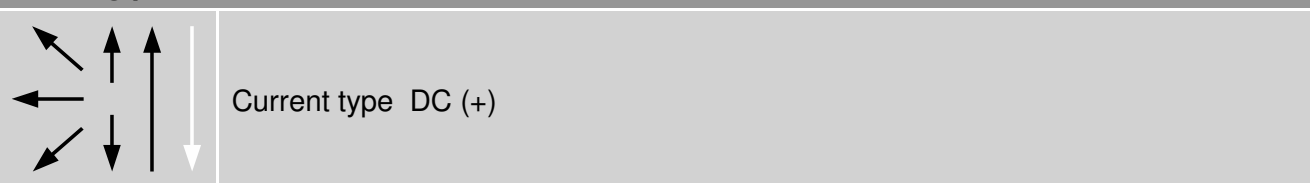
## Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength $R_m$	Elongation A	Impact strength $K_V$	
MPa	MPa	%	J	-196 °C
> 450	> 760	> 30	> 75	45

## Welding instruction

Opening angle of the prepared seam approx. 70°, root gap approx. 2 mm. Weld stick electrode with slight tilt and short arc. String beads are welded. The interpass temperature of 150° C and a max. weaving with 2,5 x diameter of the stick electrode core wire should not be exceeded. Redry the stick electrodes 2 – 3 hours at 250 – 300° C before use and weld them out of a warm electrode carrier.

## Welding positions



## Approvals

TÜV (No. 03610), DNV, ABS, GL, BV

## Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2,5 x 250	3,2 x 300	4,0 x 350	5,0 x 400
Amperage [A]	50 – 70	70 – 95	90 – 120	120 – 160