UTP 6225 Al

basic coated NiCrFe stick electrode

Classifications

EN ISO 14172	AWS A5.11	Material-No.
E Ni 6025 (NiCr25Fe10AlY)	E NiCrFe-12	2.4649

Characteristics and field of use

UTP 6225 Al is suitable for joining high-temperature and heat resistant nickel-base alloys of identical and similar nature, such as 2.4633 (NiCr25-FeAlY), 2.4851 (NiCr23Fe) and high nickel containing cast alloys.

The special features of the weld metal include an excellent resistance against oxidation and carburization and a good creep rupture strength. For service temperature up to 1200° C, e. g. steel tubes, rolls and baffles in ovens, ethylene cracking tubes, muffles.

Typical analysis in %

C	Si	Mn	Cr	Ni	Ti	Zr	Al	Fe	Y
0,2	0,6	0,1	25,0	balance	0,1	0,03	1,8	10,0	0,02

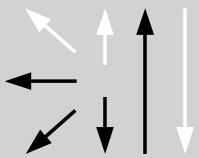
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
> 500	> 700	> 15	> 30

Welding instruction

Hold stick electrode as vertically as possible, keep a short arc. Use string beads technique and fill end crater carefully. Interpass temperature max. 150° C. Redry stick electrodes for 2 – 3 h / 250 – 300° C.

Welding positions



Current type DC (+)

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 250	3,2 x 300	4,0 x 350
Amperage [A]	50 – 65	80 – 95	90 – 120