

## UTP A 6222 Mo-3

Classifications			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 A 6222 Mo-3 has been developed for applications in the oil & gas industry, and is mainly used for cladding and joining of unalloyed and high strength low alloyed steel (HSLA) components. Typical applications are internal cladding of tubes & pipes, risers, and subsea components such as manifolds, BOPs, Christmas trees, well heads, flanges, valve bodies, blocks etc. to improve corrosion resistance to surfaces exposed to hydrocarbon and hydrogen sulphide.

Typical base metals for these applications are SAE 4130, SAE 8630, F 22, F 65. UTP A 6222 Mo-3 has excellent dissimilar materials welding characteristics and can be used for joining components produced from a variety of clad and base metal alloys such as austenitic, super austenitic, martensitic, Duplex and Super Duplex stainless steels.

UTP A 6222 Mo-3 is manufactured to optimise wire-feed and weld pool delivery characteristics, via consistent metallurgical quality raw material and physical control of wire processing, pre-requisites for successful cold and hot wire GTAW / TIG applications where the highest quality standards have to be fulfilled. The wire can also be successfully applied using the GMAW / MIG process.

UTP A 6222 Mo-3 can be welded with either cold- or hot wire automated TIG (GTAW) or MIG (GMAW) processes.

### Typical analysis in %

C	Si	Cr	Mo	Nb	Fe	Ni
≤ 0.02	≤ 0.2	22.0	9.0	3.5	≤ 0.5	balance

### Form of delivery and recommended welding parameters

Wire diameter [mm]	Current type		Shielding gas (EN ISO 14175)	
	TIG	MIG		
0.9	DC (-)	DC (+)	I 1	Z-ArHeHC-30 / 2 / 0.5
1.0	DC (-)	DC (+)	I 1	Z-ArHeHC-30 / 2 / 0.5
1.14	DC (-)	DC (+)	I 1	Z-ArHeHC-30 / 2 / 0.5
1.2	DC (-)	DC (+)	I 1	Z-ArHeHC-30 / 2 / 0.5
1.6	DC (-)	DC (+)	I 1	Z-ArHeHC-30 / 2 / 0.5