

# UTP A 6808 Mo

stainless steels

## Classifications

solid wire

EN ISO 14343-A

AWS A5.9

Material-No.

G 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 / S355N / 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

<i>Yield strength <math>R_{p0.2}</math></i>	<i>Tensile strength <math>R_m</math></i>	<i>Elongation <math>A</math></i>	<i>Impact strength <math>K_V</math></i>
<i>MPa</i>	<i>MPa</i>	<i>%</i>	<i>J (RT)</i>
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. 05551), GL

## Form of delivery and recommended welding parameters

<i>Wire diameter [mm]</i>	<i>Current type</i>	<i>Shielding gas (EN ISO 14175)</i>
1.0	DC (+)	M 12
1.2	DC (+)	M 12