

UTP A 776							
Classifications Wire for highly corrosion-resistant NiCrMo alloys							
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, such as 2.4819 NiMo16Cr15W UNS N10276 and claddings on low-alloyed steels.							
UTP A 776 is primarily used for welding components in chemical plants with highly corrosive media, but also for surfacing press tools or punches which operate at high temperatures.							
Excellent resistance against sulphuric acids and 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							
Yield strength $R_{p0.2}$		Tensile strength R_m		Elongation A		Impact strength K_v	
MPa		MPa		%		J [RT]	
> 450		> 750		> 30		> 90	
Welding instructions							
To avoid intermetallic precipitations, weld with lowest possible heat input and interpass temperature.							
Approvals							
TÜV (No. 05586)							
Form of delivery and recommended welding parameters							
Rod diameter x length [mm]		Current type		Shielding gas (EN ISO 14175)			
1.2		DC (+)		Z-ArHeHC-30/2/0.05		I 1	