

Classifications

EN ISO 12153	AWS A 5.34	Material-No.
T Ni 6625 PM 2	ENiCrMo3 T1-4	2.4621

Characteristics and field of use

The nickel-base-flux-cored wire (NiCrMo) UTP AF 6222 Mo PW is suitable for joining and surfacing on nickel-base materials of the same nature and on C- and CrNi-steels as well as for cladding on C-steels, furthermore in high temperature applications.

2.4856	NiCr22Mo9Nb	N 06625	Alloy 625
1.4539	X NiCrMoCu25 20 5	N 08904	Alloy 904
1.4583	X NiCrNb18		
1.0562	12StE 355		
1.5662	X 8Ni9		ASTM A553 Typ 1

UTP AF 6222 Mo PW distinguishes by a hot cracking resistant and tough weld metal. It is suitable for operating temperatures up to 500°C and above 800°C. It must be noted that a slight decrease in ductility will occur if prolonged heat treatment is given within the temperature range 550 - 800°C.

UTP AF 6222 Mo PW provides excellent positional welding. It has excellent welding properties with a regular and fine drop transfer. The weld seam is finely rippled and the transition from weld to base materials is regular and notch-free. The wide parameter range enables an application on different wall thicknesses.

Typical analysis in %

C	Si	Mn	P	S	Cr	Mo	Ni	Nb	Fe
0,03	0,4	0,4	0,01	0,01	21,5	9,0	balance	3,5	0,5

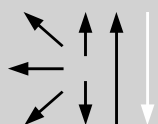
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V	
MPa	MPa	%	J [RT]	- 196 °C
490	750	30	70	60

Welding instruction

Clean welding area cautiously, slightly trailing torch position.

Welding positions



Current type DC (+)
Shielding gas: M21

Approvals

TÜV (No.10991)

Recommended welding parameters

Wire Diameter [mm]	Amperage [A]	Voltage [V]
1,2	170-200	26-32