

Classifications						
EN ISO 14343-A		AWS A5.9		Material-No.		
G 13 4 (Si)		~ ER 410 NiMo		1.4351		
Characteristics and field of use						
<p>UTP A 6635 is used for joining and building up on identical and similar martensitic CrNi cast steels for the water turbine- and compressor construction with steels.</p> <p>The weld deposit of UTP A 6635 is stainless and corrosion resistant as 13%-Cr(Ni)-steels. It presents a high resistance to corrosion fatigue.</p>						
Base materials						
1.4317		G-X4 CrNi 13-4				
1.4313		X3 CrNiMo 13-4				
1.4351		X3 CrNi 13-4				
1.4414		G-X4 CrNiMo 13-4				
ACI Gr. CA6NM						
Typical analysis in %						
C	Si	Mn	Cr	Mo	Ni	Fe
0.03	0.7	0.7	13.5	0.55	4.5	balance
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)
> 600		> 800		15		> 40
Welding instruction						
<p>For similar materials up to 10 mm wall thickness, preheating is not necessary. From 10 mm wall thickness and up, preheating at 100 – 150 °C should be provided.</p>						
Wire diameter [mm]		Current type		Shielding gas (EN ISO 14175)		
1.2		DC (+)		M 12		