

Standards :

EN 1600 : E 25 9 3 Cu N LB 42

UTP 6809 MoCuKb

Basic-coated stick electrode for Super Duplex steels
Application field

UTP 6809 MoCuKb is a basic coated stick electrode with austenitic/ ferritic deposit for joining and building up on corrosion resistant Super Duplex steels and cast steels with Cu addition. The deposit is highly resistant to crevice corrosion and stress corrosion cracking in high chloride containing medias.

Base materials

1.4517

Properties of the weld metal

The weld deposit of **UTP 6809 MoCuKb** is stainless, IK-resistant (wet corrosion 250 °C), has a good resistance to stress corrosion cracking in chloride- and phosphor-containing media. Due to its high Cr- and Mo-content, it is also resistant to pitting.

Mechanical properties of the weld metal

| Yield strength R _{p0,2} MPa | Tensile strength R _m MPa | Elongation A % | Impact strength K _v Joule |
|--|---|----------------------|--|
| 650 | 850 | 25 | 45 |

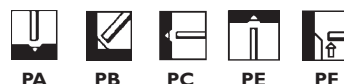
Weld metal analysis in %

| C | Si | Mn | Cr | Mo | Ni | N | Cu | Fe |
|-------|-----|-----|------|-----|-----|-----|-----|---------|
| 0,025 | 0,5 | 1,2 | 25,0 | 3,0 | 9,5 | 0,2 | 3,0 | balance |

Welding instruction

Welding area must be degreased and thoroughly cleaned to metallic bright. Preheating and post weld heat treatment of similar materials are usually not necessary. If requested a solution heat treatment at 1120°C may be carried out.

Current type

Welding positions

Availability / Current adjustments

| Stick electrodes | ∅ mm x L | 2,5 x 300 | 3,2 x 350 | 4,0 x 400 |
|------------------|----------|-----------|-----------|-----------|
| Amperage | A | 50 - 75 | 70 - 110 | 90 - 150 |