

UTP A 6635

Standards :

Material-No. : I.435I
 EN ISO 14343-A : G(W) 13 4 (Si)
 AWS A5.9 : ~ ER 410 NiMo

**MIG/MAG gas shielded welding wire
 for martensitic steels**

Application field

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.

Properties of the weld metal

The weld deposit of **UTP A 6635** is stainless and corrosion resistant as 13%-Cu(Ni)-steels. It presents a high resistance to corrosion fatigue.

Base materials

I.4317 G-X4 CrNi 13-4
 I.4313 X3 CrNiMo 13-4
 I.4351 X3 CrNi 13-4
 I.4414 G-X4 CrNiMo 13-4
 ACI Gr: CA6NM

Mechanical properties of the weld metal

Yield strength R _{p0.2} MPa	Tensile strength R _m MPa	Elongation A %	Impact strength K _v Joule
600	800	15	40

Weld metal analysis in %

C	Si	Mn	Cr	Mo	Ni	Fe
0,03	0,7	0,7	13,5	0,55	4,5	balance

Welding instruction

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.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175		Availability	
		I I	M12	Spools	Rods
1,2	DC (+)		x	x	
2,0 *	DC (-)	x			x
2,4 *	DC (-)	x			x

* available on request

Approvals

TÜV (No. 10434)