UTP A 68 Mo

MIG/MAG gas shielded welding wire for CrNi-steels with high Mo content

Standards :

Material-No. : 1.4576
EN ISO 14343-A : G/W 19 12 3 Nb
AWS A5.9 : ER 318 (Si)

Application field

UTP A 68 Mo is aplicable for joinings and surfacings of stabilized, corrosion resistant CrNiMo steels of similar nature in the construction of chemical apparatus and vessels up to working temperatures of 120° C up to 400° C.

Base materials

1.4401 X5 CrNiMo 17-12-2
1.4404 X2 CrNiMo 17-12-2
1.4435 X2 CrNiMo 18-14-3
1.4436 X3 CrNiMo 17-13-3
1.4571 X6 CrNiMoTi 17-17-7
1.4580 X6 CrNiMoNb 17-12-2
1.4583 X10 CrNiMoNb 18-12
1.4409 G-X2 CrNiMo 19-112
UNS S31653; AISi 361L; 316Ti; 316Cb

Mechanical properties of the weld metal

Yield strength $R_{p0,2}$ MPa	Tensile strength R_m MPa	Elongation A %	Impact strength K_v Joule
460	680	35	100

Weld metal analysis in %

C	Si	Mn	Cr	Mo	Ni	Nb	Fe
0,03	0,4*	1,5	19,0	2,8	11,5	0,55	balance

* MIG/MAG wire with Si-content of 0,65 - 1,0

Welding instruction

Degrease and clean weld area thoroughly (metallic bright). Preheating and post heat treatment are usually not necessary.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175		Availability	
				Spools	Rods
		I 1	M 12	EN ISO 544	EN ISO 544
0,8	DC (+)		x	x	
1,0	DC (+)		x	x	
1,2	DC (+)		x	x	
1,6	DC (-)	x			x
2,0	DC (-)	x			x
2,4	DC (-)	x			x
3,2	DC (-)	x			x
4,0 *	DC (-)	x			x

* available on request

Approvals

TÜV (No. 04867; 04868)