

Standards

Wire

Material-No. : 2.4806
 EN ISO 18274 : S Ni 6082
 (NiCr20Mn3Nb)
 AWS A5.14 : ER NiCr-3

Flux

DIN EN 760 : SA-AB 2

UTP UP 068 HH UTP UP FX 068 HH

Combination of wire and flux for nickel
 and nickel alloys

Application field

UTP UP 068 HH in combination with **UTP UP FX 068 HH** is used for claddings in the reactor construction and for joining of similar base metals and low-alloyed steels with stainless steels:

Mat-No.	DIN	UNS-No.
2.4816	NiCr15Fe	UNS N06600
2.4817	LC-NiCr15Fe	UNS N10665
2.4851	NiCr23Fe	UNS N06601
1.4876	X 10NiCrAlTi 32 20	UNS N08800

Mechanical properties of the pure weld metal at RT

Yield strength R _{p0.2} MPa	Tensile strength R _m MPa	Elongation A %	Impact strength K _v Joule
> 350	> 600	> 35	> 100

Weld metal analysis in %

C	Si	Mn	Cr	Ni	Nb	Fe
< 0,02	< 0,2	3,0	20,0	balance	2,7	0,8

Welding procedure and availability

Ø (mm)	Welding data			Availability	
	I (A)	U (V)	V (cm/min)	Spools EN ISO 544	Fluxes
1,6	200 - 250	28 - 30	30 - 50	B 450	25 kg
2,0	250 - 350	28 - 30	30 - 50	B 450	25 kg
2,4	350 - 450	28 - 30	30 - 50	B 450	25 kg

Approvals

TÜV (No. 10416; 4383)