

Standards :
Wire

Material-No. : 2.4831
 EN ISO 18274 : S Ni 6625
 (NiCr22Mo9Nb)
 AWS A5.14 : ER NiCrMo-3

Flux

EN 760 : SA FB 2 55 AC

UTP UP 6222 Mo

UTP UP FX 6222 Mo

Wire/flux combination for high nitrogen containing steels (6Mo) and duplex-alloys

Application field

UTP UP 6222 Mo and the flux **UTP UP FX 6222 Mo** are applied for joint welding of base materials with the same or with a similar composition, e. g. Alloy 625 (UNS N06625) or NiCr22Mo9Nb, Material-No. 2.4856 or mixed combinations with stainless steels and carbon steels. Furthermore the wire-flux combination is used for cold-tough Ni-steels, e. g. X8Ni9 for LNG projects. **UTP UP 6222 Mo / UTP UP FX 6222 Mo** is also applied on alloyed or unalloyed steels for cladding of corrosion resistant plants.

Mechanical properties of the pure weld deposit

Yield strength R _{p0,2} MPa	Tensile strength R _m MPa	Elongation A %	Impact strength K _v Joule
460	725	40	> 80 at + 20° C 65 at -196° C

Chemical weld metal analysis in %

C	Si	Cr	Mo	Ni	Nb	Fe
< 0,02	< 0,2	21,0	9,0	balance	3,3	2,0

Welding instructions

The welding area has to be free from impurities (oil, paint, markings etc.). Welding must be performed with a low heat input. The maximum interpass temperature is at 150° C.
 Flux has to be re-dried prior to welding: 2 hours at 300 - 400° C.

Flux height : approx. 25 mm
 Stick out : approx. 25 mm

Welding procedure and availability

Ø (mm)	Welding data			Availability	
	I (A)	U (V)	V (cm/min)	Wire EN ISO 544	Flux
1,6	200 - 250	28 - 30	30 - 50	B 300	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
3,2	400 - 450	28 - 30	30 - 50	B 450	25 kg

Approval

TÜV (No. 03918)