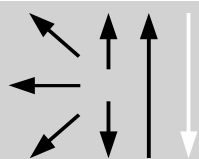


Classifications							
EN ISO 14172				AWS A5.11			
EZ Ni 6022 (NiCr21Mo13W3)				E NiCrMo-10 (mod.)			
Characteristics and field of use							
UTP 722 Kb is suited for joining materials of the same nature, as e.g. material-no. 2.4602 (NiCr21Mo14W), for joining these materials with low-alloyed steels or for cladding on low-alloyed steels. Another application field is welding of components in chemical plants which are exposed to highly corrosive media. UTP 722 Kb provides good corrosion resistance against acetic acid and acetic hydride, hot contaminated sulphuric and phosphoric acids and other contaminated oxidising mineral acids.							
Approximate weld metal analysis in %							
C	Si	Mn	Cr	Mo	Ni	W	Fe
< 0.02	< 0.2	0.8	21.0	13.5	balance	3.0	3.0
Mechanical properties of the weld metal							
Yield strength R _{p0,2}		Tensile strength R _m		Elongation A		Impact strength K _v	
MPa		MPa		%		J	
> 450		> 720		> 30		> 70	
Welding instruction							
UTP 722 Kb can be welded in all positions except vertical-down. It shows a stable arc and very easy slag removal. Opening angle of the prepared seam approx. 70°, root gap approx. 2 mm. Weld stick electrode with slight tilt and a short arc, doing string beads. An interpass temperature of 150°C and a max. weaving width of 2.5 x diameter of the stick electrode core wire should not be exceeded. Re-dry the stick electrodes 2-3 hours at 250-300°C prior to use and weld them out of a warm stick electrode holder.							
Welding positions							
				Current type DC (+)			
Electrodes Ø x L [mm]			2,5 x 250			3,2 x 300	
Amperage [A]			50 - 70			70 - 110	

Toda la información proporcionada se basa en una investigación cuidadosa e intensiva.
Sin embargo, no asumimos ninguna responsabilidad por la exactitud y la información está sujeta a cambios