

UTP A 722

nickel alloys

Classifications

TIG rod

EN ISO 18274	AWS A 5.14	Material-No.
S Ni 6022 (NiCr21Mo13Fe4W3)	ER NiCrMo-10	2.4635

Characteristics and field of use

UTP A 722 is suitable for joining materials of the same and similar nature, e.g. material-no. 2.4602 (NiCr21Mo14W / UNS N06022) and special stainless steels. Furthermore it can be used for dissimilar joints of these alloys with low-alloyed materials and cladding on low-alloyed steels.

UTP A 722 is commonly used in the production of components and plants for chemical processes involving highly corrosive media.

Good corrosion-resistance against acetic acid and its anhydride, hot contaminated sulphuric and phosphoric acids and other contaminated oxidizing mineral acids. Intermetallic precipitation is widely prevented.

Typical analysis in %

C	Si	Mn	P	S	Cr	Mo
< 0.01	< 0.1	< 0.5	< 0.015	< 0.01	21.0	13.0
Ni	V	W	Cu	Co	Fe	
balance	< 0.2	3.0	< 0.2	< 2.5	3.0	

Mechanical properties of the weld metal

<i>Yield strength $R_{p0.2}$</i>	<i>Tensile strength R_m</i>	<i>Elongation A</i>	<i>Impact strength K_V</i>
<i>MPa</i>	<i>MPa</i>	<i>%</i>	<i>J [RT]</i>
> 400	> 700	> 30	> 70

Welding instructions

The weld area has to be free from impurities such as oil, paint, markings or metal dust. Minimize heat input. The interpass temperature should not exceed 150 °C. Linear energy input < 12 kJ / cm.

Form of delivery and recommended welding parameters

<i>Rod diameter x length [mm]</i>	<i>Current type</i>	<i>Shielding gas (EN ISO 14175)</i>
2.4 x 1000	DC (-)	R 1