

Classifications												
Material-no.	EN ISO 18274						AWS A 5.14					
2.4635	S Ni 6022 (NiCr21Mo13Fe4W3)						ER NiCrMo-10					
Characteristics and field of use												
<p>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.</p> <p>UTP A 722 is commonly used in the production of components and plants for chemical processes involving highly corrosive media.</p>												
Properties of the weld metal												
<p>Good corrosion-resistance against acetic acid and its anhydride, hot contaminated sulphuric and phosphoric acids and other contaminated oxidizing mineral acids.</p> <p>Intermetallic precipitation is widely prevented.</p>												
Mechanical properties of the weld metal												
Yield strength $R_{p0.2}$			Tensile strength $R_m$				Elongation $A$			Impact strength $K_v$		
MPa			MPa				%			J [RT]		
> 400			> 700				> 30			> 70		
Typical analysis in %												
C	Si	Mn	P	S	Cr	Mo	Ni	V	W	Cu	Co	Fe
< 0.01	< 0.1	< 0.5	< 0.015	< 0.01	21.0	13.0	balance	< 0.2	3.0	< 0.2	< 2.5	3.0
Welding instruction												
<p>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 &lt; 12 kJ/cm.</p>												
Rod diameter x length [mm]				Current type				Shielding gas (EN ISO 14175)				
2.4 x 1000				DC (-)				R 1				