UTP A 6225 Al

solid wire

Classifications		
EN ISO 18274	AWS A5.14	Material-No.
S Ni 6025 (NiCr25Fe10AlY)	ER NiCrFe-12	2.4649

Characteristics and field of use

UTP A 6225 Al is suitable for welding of identical and similar alloys, such as NiCr25FeAlY, Material-No. 2.4633. These alloys are applicable for working temperatures up to 1200 °C, particularly for thermal treatment ovens.

High oxidation resistance at high temperatures (also in cyclic conditions), very good corrosion resistance in carburized medias, excellent high temperature resistance.

Typical analysis in %

C	Si	Mn	Cr	Ni	Ti	Zr	Al	Fe	Y
0.2	0.5	0.1	25.0	balance	0.15	0.05	2.0	10.0	0.08

Mechanical properties of the weld metal

Yield strength $R_{P0.2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
500	720	25	50

Welding instruction

Clean the weld area thoroughly (free of oil, scale, markings). Use stringer bead technique. Keep heat input as low as possible and interpass temperature at max. 150 °C.
UTP A 6225 Al should only be welded by using the below recommended gas.

Approvals

TÜV (No. 10135)

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
1.2	DC (+)	Z-ArHeNC-5/5/0.05