

Classifications		
EN ISO 18274	AWS A5.14	Material-No.
S Ni 6059 (NiCr23Mo16)	ER NiCrMo-13	2.4607

Characteristics and field of use														
<p>UTP A 759 is suitable for welding components in plants for chemical processes with highly corrosive media.</p> <p>For joining materials of the same or similar nature, e. g.</p> <table border="1"> <tbody> <tr> <td>2.4602</td> <td>NiCr21Mo14W</td> <td>UNS N06022</td> </tr> <tr> <td>2.4605</td> <td>NiCr23Mo16Al</td> <td>UNS N06059</td> </tr> <tr> <td>2.4610</td> <td>NiMo16Cr16Ti</td> <td>UNS N06455</td> </tr> <tr> <td>2.4819</td> <td>NiMo16Cr15W</td> <td>UNS N10276</td> </tr> </tbody> </table> <p>and these materials with low-alloyed steels such as for surfacing on low-alloyed steels.</p> <p>Good corrosion-resistance against acetic acid and acetic hydride, hot contaminated sulphuric and phosphoric acids and other contaminated oxidising mineral acids. Intermetallic precipitation will be largely avoided.</p>			2.4602	NiCr21Mo14W	UNS N06022	2.4605	NiCr23Mo16Al	UNS N06059	2.4610	NiMo16Cr16Ti	UNS N06455	2.4819	NiMo16Cr15W	UNS N10276
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Typical analysis in %					
C	Si	Cr	Mo	Ni	Fe
< 0.01	0.1	22.5	15.5	balance	< 1.0

Mechanical properties of the weld metal			
Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A	Impact strength $K_V$
MPa	MPa	%	J (RT)
> 450	> 720	> 35	> 100

Welding instructions
<p>The welding area has to be free from impurities (oil, paint, grease and dust). Minimize heat input. The interpass temperature should not exceed 150 °C. Heat input &lt; 12 kJ/cm.</p>

Approvals
TÜV (No. 06065)

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
0.8*	DC (+)	Z-ArHeHC-30/2/0.05
1.0	DC (+)	Z-ArHeHC-30/2/0.05
1.2	DC (+)	Z-ArHeHC-30/2/0.05
1.6*	DC (+)	Z-ArHeHC-30/2/0.05

\*available on request