

Classifications

EN ISO 18274	AWS A5.14	Material-No.
S Ni 6276 (NiCr15Mo16Fe6W4)	ER NiCrMo-4	2.4886

Characteristics and field of use

UTP A 776 is suitable for joint welding of matching base materials, such as 2.4819 NiMo16Cr15W UNS N10276 and claddings on low-alloyed steels.

UTP A 776 is primarily used for welding components in chemical plants with highly corrosive media, but also for surfacing press tools or punches which operate at high temperatures.

Excellent resistance against sulphuric acids and high chloride concentrations.

Typical analysis in %

C	Si	Cr	Mo	Ni	V	W	Fe
< 0.01	0.07	16.0	16.0	balance	0.2	3.5	6.0

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	> 750	> 30	> 90

Welding instruction

To avoid intermetallic precipitations, weld with lowest possible heat input and interpass temperature.

Approvals

TÜV (No. 05587)

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)	
1.6 x 1000	DC (-)	R 1	I 1
2.0 x 1000	DC (-)	R 1	I 1
2.4 x 1000	DC (-)	R 1	I 1
3.2 x 1000	DC (-)	R 1	I 1