UTP 6809 MoCuKb

Basic-coated stick electrode for super-duplex steels

Classifications

EN ISO 3581-A

E 25 9 3 Cu N LB 42

Characteristics and field of use

UTP 6809 MoCuKb is a basic-coated stick electrode with an austenitic/ferritic deposit for joining and build-up welding on corrosion-resistant super-duplex steels and cast steels with Cu addition. The deposit is highly resistant to pitting, crevice corrosion and stress corrosion cracking in high-chloride-containing media.

Base material: 1.4517

The weld deposit of UTP 6809 MoCuKb is stainless, intergranular-corrosion-resistant (wet corrosion 250°C), has a good resistance to stress corrosion cracking in chloride- and phosphor-containing media. Thanks to its high Cr and Mo content, it is also resistant to pitting.

Weld metal analysis in %

C	Si	Mn	Cr	Mo	Ni	N	Cu	Fe
0.025	0.5	1.2	25.0	3.0	9.5	0.2	3.0	balance

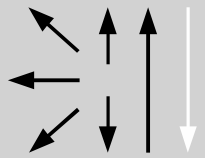
Mechanical properties of the weld metal

Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J [RT]
650	850	> 20	45

Welding instruction

Weld area must be degreased and thoroughly cleaned to a bright metallic finish. Preheating and post-weld heat treatment of similar materials are usually not necessary. Interpass temperature < 100°C, if required, a solution heat at 1,120°C may be carried out.

Welding positions



Current type DC (+)

Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 400
Amperage [A]	50-75	70-110	90-150

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.