UTP UP 068 HH

SAW solid wire

Classifications		
EN ISO 18274	AWS A5.14	Material-No.
S Ni 6082 (NiCr20Mn3Nb)	ER NiCr-3	2.4806

Characteristics and field of use

UTP UP 068 HH is used for claddings in the reactor construction and for joining of similar base metals and low-alloyed steels with stainless steels:

Mat-No.	DIN	UNS-No.
2.4816	NiCr15Fe	UNS N06600
2.4817	LC-NiCr15Fe	UNS N10665
1.4876	X 10NiCrAlTi 32 20	UNS N08800

Typical analysis in %

C	Si	Mn	Cr	Ni	Nb	Fe
< 0,02	< 0,2	3,0	20,0	balance	2,7	0,8

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]
> 350	> 600	> 35	> 100

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Travel Speed [cm/min]
1,6	200-250	28-30	30-50
2,0	250-350	28-30	30-50
2,4	350-450	28-30	30-50

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.