UTP UP 776

SAW solid wire

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

Characteristics and field of use

UTP UP 776 is suitable for joining and surfacing on matching and similar alloys such as 2.4819 NiMo16Cr15W UNS N10276 and surface weldings on low-alloyed steels.

UTP UP 776 is employed primarily for welding components in plants for chemical processes with high corrosion resistance in reducing and, above all, in oxidizing environments.

UTP UP 776 is also used for cryogenic applications such as joining 9% Ni steels.

Typical analysis in %

C	Si	Mn	P	S	Cr	Mo	Ni	W	Fe
0,02	0,25	1,0	0,008	0,006	16,0	15,5	balance	3,5	6,5

Mechanical properties of the weld metal according to EN ISO 15792-1 (min. values at RT)

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J [RT]
≥ 450	≥ 690	≥ 35	> 70

Welding instruction

The welding area has to be free of impurities (oil, paint, grease, markings and so on). Welding must be performed with low heat input. The maximum interpass temperature should be kept below 150 °C. Using dried welding flux is mandatory.

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Travel Speed [cm/min]
1,6	200-250	26-30	40-50
2,4	280-350	26-30	40-50

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.