UTP 722 Kb

Basic coated stick electrode
for highly corrosion resistant NiCrMo alloys (C22)

Classifications	
EN ISO 14172	AWS A5.11
EZ Ni 6022 (NiCr21Mo13W3)	E NiCrMo-10 (mod.)

Characteristics and field of use

UTP 722 Kb is suited for joining materials of the same nature, as e.g. material-no. 2.4602 (NiCr21Mo14W), for joining these materials with low-alloyed steels or for cladding on low-alloyed steels. Another application field is welding of components in chemical plants which are exposed to highly corrosive media. UTP 722 Kb provides good corrosion resistance against acetic acid and acetic hydride, hot contaminated sulphuric and phosphoric acids and other contaminated oxidising mineral acids.

Approximate weld metal analysis in %

C	Si	Mn	Cr	Mo	Ni	W	Fe
< 0.02	< 0.2	0.8	21.0	13.5	balance	3.0	3.0

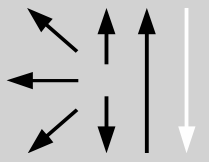
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
> 450	> 720	> 30	> 70

Welding instruction

UTP 722 Kb can be welded in all positions except vertical-down. It shows a stable arc and very easy slag removal.
Opening angle of the prepared seam approx. 70°, root gap approx. 2 mm. Weld stick electrode with slight tilt and a short arc, doing string beads. An interpass temperature of 150°C and a max. weaving width of 2.5 x diameter of the stick electrode core wire should not be exceeded. Re-dry the stick electrodes 2-3 hours at 250-300°C prior to use and weld them out of a warm stick electrode holder.

Welding positions



Current type DC (+)

Electrodes Ø x L [mm]	2,5 x 250	3,2 x 300
Amperage [A]	50 - 70	70 - 110

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.