

## DESCRIPTION

- Basic agglomerated flux designed for welding and cladding nickel alloys.
- Suitable for cryogenic steels applications: 5% & 9%Ni steels in combination with NiCr-3 & NiCrMo-3 wires.

## GENERAL CHARACTERISTICS

- Current DC ( + and - ) and AC – 800 A max.
- Basicity index 2.1 ( according to Bonizewski; calculated in mole % ).
- Grain size 0.4 – 1.4 mm ( 14 x 40 N° ASTM ).
- Apparent density 1.0
- Consumption 1 ( kg fused flux / kg wire ).
- Redrying 1 to 2 hours at 350 +/- 50°C.

## APPROVALS

TÜV (Kenblatt Nr. 09413.01) : in combination with SOUDOR 625 (~UP 6222 Mo)

## TYPICAL ALL-WELD METAL ANALYSIS OF WIRE/FLUX COMBINATION (WEIGHT%)

Wire	AWS A5.14	EN-ISO 18274	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Ti
UP 6222 Mo	ER NiCrMo-3	S Ni 6625	0.01	0.1	0.15	22	balance	9.0	3.6	<0.5	+
Weld metal		(NiCr22Mo9Nb)	0.01	2.10	0.35	21.5	balance	8.5	3.3	0.4	+
UP 068 HH	ER NiCr-3	S Ni 6082	0.015	3.1	0.15	20.5	balance	-	2.6	<1	+
Weld metal		(NiCr20Mn3Nb)	0.01	5.0	0.45	20.0	balance	-	2.1	<1	+

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Wire	Rm [MPa]	Rp0.2 [MPa]	A5 [%]	Av [ISO – V]
UP 6222 Mo	730	460	40	70 J : -196°C
UP 068 HH	600	350	40	90 J : -196°C

## SUITABLE FOR

Alloy	UNS	DIN	W. – Nr.	UP 068 HH	UP 6222 Mo
600	N06600	NiCr 15 Fe	2.4640	x	x
601	N06601	NiCr 23 Fe	2.4851	x	x
800	N08800	X10 NiCrAlTi32 20	1.4876	x	x
800H	N08810	X10 NiCrAlTi32 20	1.4958	x	x
75	N06075	NiCr 20 Ti	2.4951	x	x
80A	N07080	NiCr 20 TiAl	2.4952	x	x
90	N07090	NiCr 20 Co18 Ti	2.4969	x	x
9% Ni	K81340	X8 Ni9	1.5662	x	x
625	N06625	NiCr 22 Mo9 Nb	2.4856	-	x
825	N08825	NiCr 21 Mo	2.4858	-	x

## PACKING

25 kg (pail) : SAP stock number : 29078