

DESCRIPTION

- Highly basic agglomerated flux designed for welding and cladding of NiCr(Mo) alloys.
- Highly resistant against hot cracking thanks to its low level of Si pick up.

GENERAL CHARACTERISTICS

- Current DC (+ and -) and AC – 800 A max
- Basicity index 5.1 (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

Wires	TÜV Kennbl.-Nr.
Soudor NiCr 3 (~UTP UP 068 HH)	06540-03
Soudor 625 UP (~UTP UP 6222 Mo)	04810-03

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

Wire	ASME 5.14	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	bal	9.0	3.6	<0.5	+
Weld metal		(NiCr22Mo9Nb)	0.015	0.2	0.3	21.5	bal	8.5	3.3	0.4	+
UP 068 HH	ER NiCr-3	S Ni 6082	0.015	3.1	0.15	20.5	bal	-	2.6	<1	+
Weld metal		(NiCr20Mn3Nb)	0.01	2.9	0.35	20.0	bal	-	2.4	<1	+

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Wire	Rm [MPa]	Rp0.2 [MPa]	A5 [%]	Av [ISO – V]	
				+ 20° C	-196° C
UP 6222 Mo	720	450	40	-	70 J
UP 068 HH	600	370	40	120 J	100 J

SUITABLE FOR

Alloy	UNS	DIN	W. – Nr.	UP 068 HH	UP 6222 Mo
600	N06600	NiCr15 Fe	2.4640	x	x
601	N06601	NiCr23 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	NiCr20 Ti	2.4951	x	x
80A	N07080	NiCr20 TiAl	2.4952	x	x
90	N07090	NiCr20 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	NiCr21 Mo	2.4858	-	x

PACKING

25 kg (pail) : SAP stock number : 29076