

Classifications							
EN ISO 18274		AWS A5.14			Material-No.		
S Ni 6276 (NiCr15Mo16Fe6W4)		ER NiCrMo-4			2.4886		
Characteristics and field of use							
<p>UTP A 776 is suitable for joint welding of matching base materials, such as 2.4819 NiMo16Cr15W UNS N10276 and claddings on low-alloyed steels.</p> <p>UTP A 776 is primarily used for welding components in chemical plants with highly corrosive media, but also for surfacing press tools or punches which operate at high temperatures.</p> <p>Excellent resistance against sulphuric acids and high chloride concentrations.</p>							
Typical analysis in %							
C	Si	Cr	Mo	Ni	V	W	Fe
< 0.01	0.07	16.0	16.0	balance	0.2	3.5	6.0
Mechanical properties of the weld metal							
Yield strength $R_{p0,2}$		Tensile strength R_m		Elongation A		Impact strength CVN [J]	
MPa		MPa		%		+20 °C	
> 450		> 750		> 30		> 90	
Welding instructions							
To avoid intermetallic precipitations, weld with lowest possible heat input and interpass temperature.							
Approvals							
TÜV (No. 05586)							
Wire diameter [inch]		Current type			Shielding gas (EN ISO 14175)		
0,045 (1,2 mm)		DC (+)			Z-ArHeHC-30/2/0.05		I 1