UTP 759 Kb

basic coated NiCrMo stick electrode

Classifications		
EN ISO 14172	AWS A5.11	Material-No.
E Ni 6059 (NiCr23Mo16)	E NiCrMo-13	2.4609

Characteristics and field of use

UTP 759 Kb is employed primarily for welding components in environmental plants and plants for chemical processes with highly corrosive media. Joint welding of matching base materials as Material-No. 2.4605 or similar matching materials as material No 2.4602 NiCr21Mo14W. Joint welding of these materials with low-alloyed steels. Cladding on low-alloyed steels.

In addition to its good resistance to contaminated oxidating mineral acids, acetic acids and acetic anhydrides, hot contaminated sulphuric - and phosphoric acid, UTP 759 Kb has an excellent resistance against pitting and crevice corrosion. The special composition of the coating extensively prevents the precipitation of intermetallic phases.

UTP 759 Kb can be welded in all positions except vertical down. Stable arc, easy slag removal.

Typical analysis in %

C	Si	Mn	Cr	Mo	Ni	Fe
< 0,02	< 0,2	0,5	22,5	15,5	balance	1,0

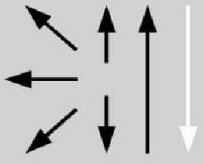
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
> 450	> 720	> 30	> 60

Welding instruction

Opening angle of the prepared seam approx. 70° C, root gap approx. 2 mm. Weld stick electrode with slight tilt and with a short arc. String beads are welded. The interpass temperature of 150° C and a max. weaving width 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 before use and weld them out of a warm stick electrode carrier.

Welding positions



Current type DC (+)

Approvals

TÜV (No. 06687)

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 250	3,2 x 300	4,0 x 350
Amperage [A]	50 – 70	70 – 100	90 – 130