

## Classifications

EN ISO 18274	AWS A5.14	Material-No.
S Ni 6059 (NiCr23Mo16)	ER NiCrMo-13	2.4607

## Characteristics and field of use

UTP A 759 is suitable for welding components in plants for chemical processes with highly corrosive media.

For joining materials of the same or similar nature, e. g.

2.4602 NiCr21Mo14W UNS N06022

2.4605 NiCr23Mo16Al UNS N06059

2.4610 NiMo16Cr16Ti UNS N06455

2.4819 NiMo16Cr15W UNS N10276

and these materials with low-alloyed steels such as for surfacing on low-alloyed steels.

Good corrosion-resistance against acetic acid and acetic hydride, hot contaminated sulphuric and phosphoric acids and other contaminated oxidising mineral acids. Intermetallic precipitation will be largely avoided.

## Typical analysis in %

C	Si	Cr	Mo	Ni	Fe
< 0.01	0.1	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 (RT)
> 450	> 720	> 35	> 100

## Welding instructions

The welding area has to be free from impurities (oil, paint, grease and dust). Minimize heat input. The interpass temperature should not exceed 150 °C. Heat input < 12 kJ/cm.

## Approvals

TÜV (No. 06065)

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
0.8*	DC (+)	Z-ArHeHC-30/2/0.05
1.0	DC (+)	Z-ArHeHC-30/2/0.05
1.2	DC (+)	Z-ArHeHC-30/2/0.05
1.6*	DC (+)	Z-ArHeHC-30/2/0.05

\*available on request