

Classifications		
EN ISO 18274	AWS A5.14	Material-No.
S Ni 6025 (NiCr25Fe10AlY)	ER NiCrFe-12	2.4649

Characteristics and field of use
<p>UTP A 6225 AI is suitable for welding of identical and similar alloys, such as NiCr25FeAlY, Material-No. 2.4633. These alloys are applicable for working temperatures up to 1200 °C, particularly for thermal treatment ovens.</p> <p>High oxidation resistance at high temperatures (also in cyclic conditions), very good corrosion resistance in carburized medias, excellent high temperature resistance.</p>

Typical analysis in %									
C	Si	Mn	Cr	Ni	Ti	Zr	Al	Fe	Y
0.2	0.5	0.1	25.0	balance	0.15	0.05	2.0	10.0	0.08

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)
500	720	25	50

Welding instruction
<p>Clean the weld area thoroughly (free of oil, scale, markings). Use stringer bead technique. Keep heat input as low as possible and interpass temperature at max. 150 °C. UTP A 6225 AI should only be welded by using the below recommended gas.</p>

Approvals		
TÜV (No. 10135)		
Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
1.2	DC (+)	Z-ArHeNC-5/5/0.05