Standards:

Material Nº	: 2.4806
DIN 1736	: SG-NiCr20Nb
DIN EN ISO 18274	: S Ni 6082 (NiCr20Mn3Nb)
AWS A 5.14	: ER NiCr-3

UTP A 068 HH

NiCrFe wires and rods resistant to corrosion and high temperatures.

Application Field

UTP A 068 HH rod/wire is mostly used to junction similar nickel alloys resistant to high temperatures, austenitic alloys in high temperatures and junction of austenitic-ferritic steel resistant to high temperatures, such as:

	NiCr15Fe	2.4816	UNS N06600
LC-	NiCr15Fe	2.4817	UNS N10665
	NiCr23Fe	2.4851	UNS N06601
	NIMONIC75		UNS N06075
X10	NiCrAlTi 32 20	1.4876	UNS N08800
X3	CrNiN 18 10	1.6907	

Specially used to junction fused 25/35 CrNi alloys with high C content with 1.4859 or 1.4876 materials in petrochemical plants with working temperature of up to 900ºC. The deposited metal is resistant to hot cracks and it is not weakened.

Mechanical Properties of the Deposited Metal

Flow Limit $R_{p0.2}$ (MPa)	Resistance Limit R_m (MPa)	Stretching A (%)	Resistance to Impact K_v (J)
>420	>640	>35	20ºC > 200 -196ºC > 100

Chemical Analysis of the Deposited Metal (%)

C	Si	Mn	Ni	Cr	Nb	Fe
0.04	0.090	3.00	72.7	19.9	2.40	1.00

Welding Instructions:
Clean the surface to be welded (shinny metal). Keep the welding energy low and interpass temperature of 150ºC, at most.

Protection gas according to EN 439:

TIG	I1 (Argon)
MIG	I1 (Argon)
MAG	M11 + 28 He

Packages

Rods	Ø mm X 1000 mm	1.6	2.0	2.4	3.2*
Wires	Ø mm	0.8*	1.0	1.2	1.6*

* Upon demand.