

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. 10145)									
Rod diameter x length [mm]			Current type			Shielding gas (EN ISO 14175)			
2,0 x 1000			DC (-)			N2-ArN-2			
2,4 x 1000			DC (-)			N2-ArN-2			
3,2 x 1000			DC (-)			N2-ArN-2			