

## Classifications

EN ISO 14172	AWS A5.11	Material-No.
E Ni 6182 (NiCr15Fe6Mn)	E NiCrFe-3	2.4807

## Characteristics and field of use

UTP Soudonel is a synthetic basic-coated nickel-base stick electrode used for joining and cladding of high-temperature resistant Ni alloys, cold-tough steels and stainless steels. UTP Soudonel can also be used for dissimilar joining of these materials, especially for repair jobs where good elongation of the pure weld metal is requested.

C	Si	Mn	Cr	Nb	Fe	Ni
0.04	0.4	8.2	16.0	1.9	7.5	Balance

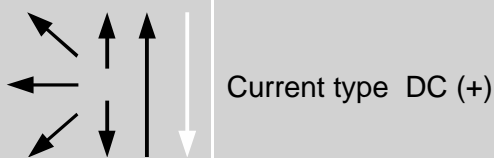
## Mechanical properties of the weld metal

Yield strength $R_{p0,2}$	Tensile strength $R_m$	Elongation A	Impact strength $K_v$
MPa	MPa	%	J
380	600	30	80

## Welding instruction

The weld zone must be bare and properly degreased. Prior to welding, the electrodes must be pre-dried for 2-3 hours at 250-300°C. The electrode is welded with a slight tilt, short arc and sufficiently high amperage adjustment. To avoid end crater cracks the crater must be filled properly and the arc drawn away to the side.

## Welding positions



## Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2,5 x 350	3,2 x 350	4,0 x 350	5,0 x 450
Amperage [A]	75 - 100	100 - 140	140 - 180	170 - 220