

## Classifications

EN ISO 1071

EZ FeC-GF

## Characteristics and field of use

UTP 5 D is suited for cast iron hot welding (identical in colour and structure) nodular cast iron (GJS) and grey cast iron (GJL). The mechanical properties are obtained by heat treatment in accordance with the base metal being used.

UTP 5 D has a smooth arc and little slag, therefore, slag removal on pipe cavity and repair welds is not necessary.

## Typical analysis in %

C	Si	Mn	Fe
3,0	3,0	0,4	balance

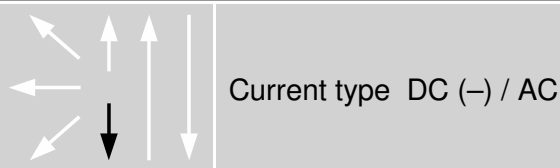
## Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength $R_m$	Hardness
MPa	MPa	HD
approx. 350	approx. 550	approx. 220

## Welding instruction

Preheating of weldment to 550 – 650° C. Interpass temperature at a minimum of 550° C. Slow cooling of the weldment (< 30° C / h) or covered cooling.

## Welding positions



## Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	3,2 x 350*	4,0 x 450*	8,0 x 450*
Amperage [A]	75 – 140	110 – 160	250 – 300

\*available on request