

## Classifications

EN ISO 3581-A	AWS A5.4	Material-No.
E 13 4 B 4 2	E 410 NiMo	1.4351

## Characteristics and field of use

UTP 6635 is a basic-coated stick electrode for joinings and surfacings on corrosion resistant martensitic CrNi-steels and corresponding cast steels. The application field is in the armatures- and power station construction. The weld deposit has an increased resistance to cavitation and erosion also at working temperatures up to 350°C.

UTP 6635 is weldable in all positions, except vertical-down. Easy slag removal, smooth and notch-free welding surface. Recovery: 130 %.

## Base materials

1.4313, 1.4407, 1.4413, 1.4414

## Typical analysis in %

C	Si	Mn	Cr	Ni	Mo	Fe
0,03	0,25	0,8	13,0	4,0	0,45	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
650	760	15	55

## Welding instruction

Weld stick electrode slightly inclined with a short arc. For a wall thickness > 10 mm, a preheating of max. 150°C is recommended. Redrying 2 – 3 h at 250 – 350° C.

## Welding positions



## Approvals

TÜV (No. 05067)

## Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2,5 x 350	3,2 x 350	4,0 x 450	5,0 x 450
Amperage [A]	60 – 80	70 – 100	110 – 160	150 – 190