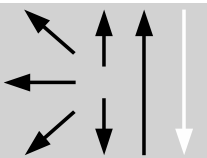


| Classifications | | | | | | | |
|--|-----------|------------------------|-----------|----------------|--------------|-----------------------|---------|
| EN ISO 3581-A | | AWS A5.4 | | | Material-No. | | |
| E 19 12 3 Nb R 3 2 | | E 318 - 16 | | | 1.4576 | | |
| Characteristics and field of use | | | | | | | |
| <p>The rutile coated stick electrode UTP 68 Mo is used for joining and surfacing of stabilized and non stabilized CrNiMo steels and CrNiMo cast steels. The deposit is IC resistant with stabilized base material up to + 400°C working temperature.</p> <p>The stick electrode is weldable in all positions except vertical down. Even flow, very easy slag removal. Smooth, notch-free seam surface.</p> | | | | | | | |
| Base materials | | | | | | | |
| 1.4401, 1.4404, 1.4408, 1.4436, 1.4571, 1.4580, 1.4581, 1.4583 | | | | | | | |
| Typical analysis in % | | | | | | | |
| C | Si | Mn | Cr | Mo | Ni | Nb | Fe |
| 0,025 | 0,8 | 0,6 | 18,0 | 2,7 | 12,0 | 0,25 | 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 | | 560 | | 30 | | 55 | |
| Welding instruction | | | | | | | |
| Clean the weld zone and above all degrease it. Keep a short arc. Weld with dry stick electrodes. Redry for 2 h at 120 – 200° C. | | | | | | | |
| Welding positions | | | | | | | |
|  <p>Current type DC (+) / AC</p> | | | | | | | |
| Approvals | | | | | | | |
| TÜV (No. 02593) | | | | | | | |
| Recommended welding parameters | | | | | | | |
| Electrodes $\varnothing \times L$ [mm] | 1,5 x 250 | 2,0 x 300 | 2,5 x 350 | 3,2 x 350 | 4,0 x 350 | 5,0 x 450 | |
| Amperage [A] | 25 – 40 | 40 – 60 | 50 – 90 | 80 – 120 | 120 – 160 | 140 – 200 | |