UTP 68 MoLC

low carbon stick electrode

Classifications		
EN ISO 3581-A	AWS A5.4	Material-No.
E 19 12 3 L R 3 2	E 316 L-17	1.4430

Characteristics and field of use

The rutile coated stick electrode UTP 68 MoLC, with a low C content, is used for joining and surfacing of identical, low carbon, austenitic CrNiMo steels and CrNiMo cast steels. The weld deposit has, due to the low C content, a high resistance to intercristalline corrosion and can be used for working temperatures up to + 400°C.

The stick electrode is weldable in all positions except vertical down. The weld deposit is smooth and fine rippled. Slag removal is very easy and without residues.

Base materials

1.4401, 1.4404, 1.4436, 1.4571, 1.4573, 1.4580, 1.4583

Typical analysis in %

C	Si	Mn	Cr	Ni	Mo	Fe
0,025	0,8	0,5	18,0	12,0	2,8	balance

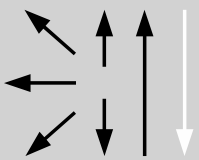
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
380	560	30	60

Welding instruction

The stick electrode should be welded slightly inclined and with a short arc. Redrying
2 hours at 120 – 200° C.

Welding positions



Current type DC (+) / AC

Approvals

TÜV (No. 00101), ABS, DB (No. 30.138.03), GL, DNV

Recommended welding parameters

Electrodes Ø x 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