

## Classifications

EN ISO 3581-A	AWS A5.4	Material-No.
E 23 12 L R 32	E 309 L-17	~ 1.4332

## Characteristics and field of use

The rutile coated stick electrode UTP 6824 LC is used for joining and surfacing of stainless and heat resistant steels / cast steels as well as for dissimilar metal joints (heterogeneous joints) and for buffer layers on corrosion - or wear resistant claddings on C-steels. The weld deposit is scale resistant up to + 1000° C.

The stick electrode is weldable in all positions except vertical-down. It is distinguished by a stable arc, minimal spatter, and very good slag removal. The weld seam is regularly marked and free of pores.

## Base materials

1.4541, 1.4550, 1.4583, 1.4712, 1.4724, 1.4742, 1.4825, 1.4826, 1.4828

Joining these materials with unalloyed and low-alloyed steels is possible.

## Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0,025	0,8	0,8	22,5	12,5	balance

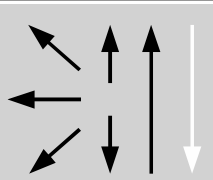
## Mechanical properties of the weld metal

Yield strength $R_{p0,2}$	Tensile strength $R_m$	Elongation A	Impact strength $K_V$
MPa	MPa	%	J
> 390	> 550	> 30	> 47

## Welding instruction

Weld the stick electrode slightly inclined with a short arc. For claddings, the preheating and interpass temperature should be adjusted according to the base material. Redrying 2 h at 120 – 200° C.

## Welding positions



Current type DC (+) / AC

## Approvals

TÜV (No. 04074), GL, DNV

## 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	80 – 110	110 – 140	140 – 180

\*available on request