

Classifications		
EN ISO 14343-A	AWS A5.9	Material-No.
W 18 8 Mn	ER 307 (mod.)	1.4370

**Characteristics and field of use**

UTP A 63 is suitable for particularly crack resistant joining and surfacing of high-strength ferritic and austenitic steels, hard manganese steels and cold-tough steels, as cushioning layer under hard alloys, dissimilar metal joints.

The weld metal of UTP A 63 is scale resistant up to 850° C, cold-tough to  $-110^{\circ}$  C. Work hardening.

Hardness of the pure weld metal: approx. 200 HB

Typical analysis in %					
C	Si	Mn	Cr	Ni	Fe
0,08	0,8	6,5	19,5	9,0	balance

Mechanical properties of the weld metal		
Yield strength $R_{P0,2}$	Tensile strength $R_m$	Elongation A
MPa	MPa	%
> 370	> 600	> 30

**Welding instruction**

Clean weld area thoroughly. Thick walled, ferritic elements have to be preheated to approx. 150-250° C.

**Approvals**

TÜV (No. 04097)

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
1,2 x 1000*	DC (-)	I 1
1,6 x 1000	DC (-)	I 1
2,0 x 1000	DC (-)	I 1
2,4 x 1000	DC (-)	I 1
3,2 x 1000	DC (-)	I 1

\*available on request