

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

Characteristics and field of use
<p>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.</p> <p>The weld metal of UTP A 63 is scale resistant up to 850 °C, cold-tough to –110 °C. Work hardening.</p> <p>Hardness of the pure weld metal: approx. 200 HB</p>

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. 04096), DB (No. 43.138.02)

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
0,8	DC (+)	M 12
1,0	DC (+)	M 12
1,2	DC (+)	M 12
1,6	DC (+)	M 12