

Classifications

EN ISO 14343-A	AWS A5.9	Material-No.
G 29 9	ER 312	1.4337

Characteristics and field of use

UTP A 651 is suitable for joining and surfacing of steels of difficult weldability, repair of hot and cold working steels, cushioning layers.

The weld metal of UTP A 651 is scale resistant up to 1150 °C. Crack and wear resistant, stainless and work hardening.

Hardness of the pure weld metal: approx. 240 HB.

Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0.1	0.4	1.6	30.0	9.0	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 (RT)
650	750	25	27

Welding instruction

Clean weld area thoroughly. High carboned and solid work pieces depending on shape and size have to be preheated up to 150 – 250 °C. Steady guidance during welding process.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)	
0.8*	DC (+)	M 12	M 13
1.0*	DC (+)	M 12	M 13
1.2	DC (+)	M 12	M 13

*available on request