

Classifications					
EN ISO 14343-A	AWS A5.9	Material-No.			
W 19 9 L (Si)	ER 308 L (Si)	1.4316			
Characteristics and field of use					
UTP A 68 LC is suitable for joining and surfacing in chem. apparatus and vessel construction for working temperatures of -196°C up to 350°C .					
Base materials					
1.4301	X5 CrNiNi 18-10				
1.4306	X2 CrNi 19-11				
1.4311	X2 CrNiN 18-10				
1.4312	G-X10 CrNi 18-8				
1.4541	X6 CrNiTi 18-10				
1.4546	X5 CrNiNb 18-10				
1.4550	X6 CrNiNb 18-10				
AISI 304; 304L; 302; 321; 347					
ASTM A 1576 Gr. C 9; A 320 Gr. B 8 C or D					
Typical analysis in %					
C	Si	Mn	Cr	Ni	Fe
0,02	0,4	1,5	20,0	10,0	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]		
400	600	35	100		
Approvals					
TÜV (No. 05831)					
Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)			
1,0 x 1000*	DC (-)	I 1			
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					