

Classifications					
EN ISO 14343-A		AWS A5.9		Material-No.	
G 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 $-196\text{ }^{\circ}\text{C}$ up to $350\text{ }^{\circ}\text{C}$.					
Base materials					
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 oder D					
Typical analysis in %					
C	Si	Mn	Cr	Ni	Fe
0.02	0.65 – 1.0	1.5	20.0	10.0	balance
Mechanical properties of the weld metal					
Yield strength $R_{P0.2}$		Tensile strength R_m		Elongation A	
MPa		MPa		%	
400		600		35	
			Impact strength K_V		
			J (RT)		
			100		
Approvals					
TÜV (No. 00184)					
Wire diameter [mm]		Current type		Shielding gas (EN ISO 14175)	
0.8		DC (+)		M 11	M 12
1.0		DC (+)		M 11	M 12
1.2		DC (+)		M 11	M 12