

Classifications							
EN ISO 14343-A		AWS A5.9			Material-No.		
W 19 12 3 Nb (Si)		ER 318 (Si)			1.4576		
Characteristics and field of use							
UTP A 68 Mo is applicable for joinings and surfacings of stabilized, corrosion resistant CrNiMo steels of similar nature in the construction of chemical apparatus and vessels up to working temperatures of 120° C up to 400° C.							
Base materials							
1.4401	X5 CrNiMo 17-12-2						
1.4404	X2 CrNiMo 17-12-2						
1.4435	X2 CrNiMo 18-14-3						
1.4436	X3 CrNiMo 17-13-3						
1.4571	X6 CrNiMoTi 17-12-2						
1.4580	X6 CrNiMoNb 17-12-2						
1.4583	X10 CrNiMoNb 18-12						
1.4409	G-X2 CrNiMo 19-112						
UNS S31653; AISi 361L; 316Ti; 316Cb							
Typical analysis in %							
C	Si	Mn	Cr	Mo	Ni	Nb	Fe
0,03	0,4	1,5	19,0	2,8	11,5	0,55	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]	
460		680		35		100	
Welding instruction							
Degrease and clean weld area thoroughly (metallic bright). Preheating and post heat treatment are usually not necessary.							
Approvals							
TÜV (No. 04868)							
Rod diameter x length [mm]		Current type			Shielding gas (EN ISO 14175)		
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		
4,0 x 1000*		DC (-)			I 1		
*available on request							