

Classifications						
EN ISO 14343-A	AWS A5.9		Material-No.			
W 19 12 3 L (Si)	ER 316 L (Si)		1.4430			
Characteristics and field of use						
UTP A 68 MoLC is used for joining and surfacing of low-carbon, corrosion resistant CrNiMo steels exposed to high corrosion for working temperatures up to +350° C. Application fields are chemical apparatus and vessels.						
Base materials						
Material-No.	EN Symbol					
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	GX2 CrNiMo 19-11-2					
	S31653, AISi 316 L, 316 Ti, 316 Cb					
Typical analysis in %						
C	Si	Mn	Cr	Mo	Ni	Fe
0,02	0,4	1,5	18,5	2,8	12,0	balance
Mechanical properties of the weld metal						
Yield strength R <sub>P0,2</sub>	Tensile strength R <sub>m</sub>		Elongation A		Impact strength K <sub>V</sub>	
MPa	MPa		%		J [RT]	
420	600		35		100	
Welding instruction						
Degrease and clean weld area thoroughly (metallic bright). Preheating and post heat treatment are usually not necessary.						
Approvals						
TÜV (No. 05832), GL						
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						