UTP A 68

solid wire

Classifications		
EN ISO 14343-A	AWS A5.9	Material-No.
G 19 9 Nb Si	ER 347 (Si)	1.4551

Characteristics and field of use

UTP A 68 is suitable for joining and surfacing in chem. apparatus and vessel construction for working temperatures of –196 °C up to 400 °C.

Base materials

1.4550	X6 CrNiNb 18-10
1.4541	X6CrNiTi 18-10
1.4552	G-X5 CrNiNb 18-10
1.4311	X2 CrNiN 18-10
1.4306	X2 CrNi 19-11

AISi 347, 321, 302, 304, 3046, 304LN
ASTM A 296 Gr. CF 8 C, A 157 Gr. C 9

Typical analysis in %

C	Si	Mn	Cr	Ni	Nb	Fe
0.05	0.65 – 1.0	1.5	19.5	9.5	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)
420	600	30	100

Welding instruction

Degrease and clean weld area thoroughly (metallic bright).
Preheating and post heat treatment are usually not necessary.

Approvals

TÜV (No. 04865)

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