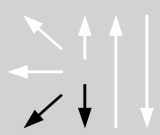


Classifications					
EN ISO 17633-A		AWS A5.22		Material-No.	
T 19 9 L RM3 T 19 9 L RC3		E 308 LT-0-1 E 308 LT-0-4		1.4316	
Characteristics and field of use					
UTP AF 68 LC is a low carbon, CrNi flux-cored wire with rutile slag used for joint-welding of alloyed CrNi-steels and cast steels. The weld metal shows sufficient grain stability up to 350° C and is scaling resistant up to 800° C.					
Base materials					
Material-No.55	AISI	UNS	EN Symbol		
1.4300	302	S30200	X12 CrNi 18 8		
1.4301	304	S30400	X5 CrNi 18 10		
1.4306	304L	S30403	X2 CrNi19 11		
1.4311	304LN	S30453	X2 CrNiN 18 10		
1.4312	305	J92701	GX10 CrNi 18 8		
1.4303	308	S30800	X4 CrNi 18 12		
1.4541	321	S32100	X6 CrNiTi 18 10		
1.4550	347	S34700	X6 CrNiNb 18 10		
Typical analysis in %					
C	Si	Mn	Cr	Ni	Fe
0,025	0,6	1,5	19,5	10,0	balance
Mechanical properties of the weld metal					
Yield strength $R_{P0,2}$		Tensile strength $R_m$		Elongation A	
MPa		MPa		%	
380		560		35	
			Impact strength $K_V$		
			J [RT]		
			70		
Welding instruction					
Clean weld area thoroughly. Welding torch should be held slightly inclined, using the pushing technique. Possibly weaving.					
Welding positions					
		Current type DC (+) Shielding gases: M20, M21, C1			
Approvals					
TÜV (No. 06365)					

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]
0,9*	100-160	22-27
1,2	125-270	20-33
1,6*	200-350	25-35

\*available on request