

UTP AF 68 MoLC

stainless steels

Classifications

Gas-shielded flux-cored wire

EN ISO 17633-A

AWS A5.22

Material-No.

T 19 12 3 L R M21 / C1 3

E 316 LT0-1 / E 316 LT0-4

1.4430

Characteristics and field of use

UTP AF 68 LC is a low carbon, CrNi flux-cored wire with rutile slag for joining and surfacing of CrNi steels and cast steel.

The weld metal shows sufficient grain stability up to 350 °C and is scaling resistant up to 800 °C.

Base materials

Material-No.	AISI	UNS	EN
1.4401	316	S31600	X5 CrNiMo 17-12-2
1.4404	316L	S31603	X2 CrNiMo 17-12-2
1.4406	316LN	S31653	X2 CrNiMoN 17-12-2
1.4571	316Ti	S31635	X6 CrNiMoTi 17-12-2
1.4583	318	S31640	X10 CrNiMoNb 18-12

Typical analysis in %

C	Si	Mn	Cr	Mo	Ni	Fe
0.025	0.6	1.5	19.5	2.7	12.5	balance

Mechanical properties of the weld metal

Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A	Impact toughness K_V
MPa	MPa	%	J [RT]
400	560	35	55

Welding instructions

Clean weld area thoroughly. Welding torch should be held slightly inclined, using the pushing technique. Possibly weaving.

Welding positions



Current type DC (+)
Shielding gases: Argon + 15 - 25 % CO₂, 100 % CO₂

Approvals

TÜV (No. 06366)

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage	Voltage [V]
0.9*	100 – 160	21 – 30
1.2	125 – 260	20 – 34
1.6*	200 – 300	25 – 35

*available on request