

UTP AF 6824 LC

stainless steels

Classifications		Gas-shielded flux-cored wire
EN ISO 17633-A	ASME II C SFA 5.22	Material-No.
T 23 12 L RM3 / T 23 12 L RC3	E 309 LT 0-1 / E 309 LT 0-4	1.4332

Characteristics and field of use

UTP AF 6824 LC is a low-carbon flux-cored wire with rutile slag used for joint-welding of alloyed CrNi steels among each other or with other unalloyed or low-alloyed steels / cast steels.
(b+w joining).

Properties of the weld metal: 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 Symbol
1.4301	304	S 30400	X5 CrNi 18 10
1.4306	304 L	S 30403	X2 CrNi 19 11
1.4311	304 LN	S 30453	X2 CrNiN 18 10
1.4401	316	S 31600	X5 CrNiMo 17 12 2
1.4404	316 L	S 31603	X2 CrNiMo 17 13 2
1.4541	308	S 30800	X6 CrNiTi 18 10
1.4550	347	S 34700	X6 CrNiNb 18 10
1.4571	316 Ti	S 31635	X6 CrNiMoTi 17 12 2
1.4583	318	S 31640	G-X5 CrNiNb 19 11

Joining these materials with unalloyed and low-alloyed steels is possible.

Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0.025	0.6	1.5	24.0	12.0	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	550	35	60

Welding instructions

Clean weld area thoroughly. Welding torch should be held slightly inclined, using the backhand (drag) technique. Possibly weaving.

Welding positions



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