UTP 68 H

fully austenitic CrNi stick electrode

Classifications

EN ISO 3581-A	AWS A5.4	Material-No.
E 25 20 R 32	E 310-16	1.4842

Characteristics and field of use

The rutile coated stick electrode UTP 68 H is suitable for joining and surfacing of heat resistant Cr-, CrSi-, CrAl-, CrNi-steels/cast steels. It is used for operating temperatures up to 1100° C in low-sulphur combustion gas. Application fields are in the engineering of furnaces, pipework and fittings.

UTP 68 H is weldable in all positions except vertical down. Fine droplet. The surface of the seams is smooth and finely rippled. Easy slag removal free from residues.

Base materials

Material-No.	DIN	Material-No.	DIN
1.4710	G-X30 CrSi 6	1.4837	G- X40 CrNiSi 25 12
1.4713	X10 CrAl 7	1.4840	G- X15 CrNi 25 20
1.4762	X10 CrAl 24	1.4841	X15 CrNiSi 25 20
1.4828	X15 CrNiSi 20 12	1.4845	X12 CrNi 25 21
1.4832	G-X25 CrNiSi 20 14	1.4848	G- X40 CrNiSi 25 20

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

Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0,10	0,6	1,5	25,0	20,0	balance

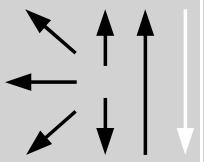
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
> 350	> 550	> 30	> 47

Welding instruction

Weld stick electrode with slight tilt and with a short arc.
Redry the stick electrodes 2 h at 120 – 200° C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	1,5 x 250*	2,0 x 250*	2,5 x 250	3,2 x 350	4,0 x 400
Amperage [A]	25 – 40	40 – 60	50 – 80	80 – 110	130 – 140

*available on request