

Classifications						
EN ISO 3581-A	AWS A5.4			Material-No.		
E 19 9 Nb R 3 2	E 347-17			1.4551		
Characteristics and field of use						
<p>The rutile coated welding stick electrode UTP 68 is suitable for joining and surfacing of stabilized and non stabilized CrNi steels and CrNi cast steels. The deposit is IC resistant with stabilized base material up to + 400°C working temperature. The stick electrode is also applicable for the 2nd layer on cladded CrNi steels.</p> <p>The stick electrode is weldable in all positions except vertical down. It has a stable arc and is spatter free. Easy ignition and re-ignition, self detaching slag. Clean and finely wrinkled bead without undercutting.</p>						
Base materials						
1.4301, 1.4312, 1.4541, 1.4550, 1.4552						
Typical analysis in %						
C	Si	Mn	Cr	Ni	Nb	Fe
0,03	0,8	0,5	19,0	10,0	0,25	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
> 380		> 590		> 30		> 47
Welding instruction						
Weld stick electrode slightly inclined with a short arc. Redrying 2 hours at 120 – 200°C.						
Welding positions						
			Current type DC (+) / AC			
Approvals						
TÜV (No. 02592), ABS, GL						
Recommended welding parameters						
Electrodes $\varnothing \times L$ [mm]	2,0 x 300	2,5 x 350	3,2 x 350	4,0 x 350		
Amperage [A]	40 – 60	50 – 90	80 – 110	110 – 140		