UTP A 63 stainless steels

Classifications		solid wire
EN ISO 14343-A	AWS A5.9	Material-No.
G 18 8 Mn	ER 307 (mod.)	1.4370

Characteristics and field of use

UTP A 63 is suitable for particularly crack resistant joining and surfacing of high-strength ferritic and austenitic steels, hard manganese steels and cold-tough steels, as cushioning layer under hard alloys, dissimilar metal joints.

The weld metal of UTP A 63 is scale resistant up to 850 °C, cold-tough to – 110 °C. Work hardening.

Hardness of the pure weld metal: approx. 200 HB

Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0.08	0.8	6.5	19.5	9.0	balance

Mechanical properties of the weld metal

Yield strength $R_{p0.2}$	*Tensile strength R_m*	*Elongation A*
MPa	*MPa*	*%*
> 370	> 600	> 30

Welding instructions

Clean weld area thoroughly. Thick walled, ferritic elements have to be preheated to approx. 150 – 250 °C.

Approvals

TÜV (No. 04096), DB (No. 43.132.58)

Form of delivery and recommended welding parameters

Wire diameter [mm]	*Current type*	*Shielding gas (EN ISO 14175)*
0.8	DC (+)	M 12
1.0	DC (+)	M 12
1.2	DC (+)	M 12
1.6	DC (+)	M 12