

**UTP A 68 LC**

stainless steels

**Classifications** solid wire

EN ISO 14343-A	AWS A5.9	Material-No.
G 19 9 L (Si)	ER 308 L (Si)	1.4316

**Characteristics and field of use**

UTP A 68 LC is suitable for joining and surfacing in chem. apparatus and vessel construction for working temperatures of  $-196^{\circ}\text{C}$  up to  $350^{\circ}\text{C}$ .

**Base materials**

1.4306	X2 CrNi 19-11
1.4311	X2 CrNiN 18-10
1.4312	G-X10 CrNi 18-8
1.4541	X6 CrNiTi 18-10
1.4546	X5 CrNiNb 18-10
1.4550	X6 CrNiNb 18-10

AISI 304; 304L; 302; 321; 347  
ASTM A 1576 Gr. C 9; A 320 Gr. B 8 C oder D

**Typical analysis in %**

C	Si	Mn	Cr	Ni	Fe
0.02	0.65 – 1.0	1.5	20.0	10.0	balance

**Mechanical properties of the weld metal**

<i>Yield strength <math>R_{p0.2}</math></i>	<i>Tensile strength <math>R_m</math></i>	<i>Elongation <math>A</math></i>	<i>Impact strength <math>K_V</math></i>
<i>MPa</i>	<i>MPa</i>	<i>%</i>	<i>J (RT)</i>
400	600	35	100

**Approvals**

TÜV (No. 00184)

**Form of delivery and recommended welding parameters**

<i>Wire diameter [mm]</i>	<i>Current type</i>	<i>Shielding gas (EN ISO 14175)</i>		
0.8	DC (+)	M 11	M 12	M 13
1.0	DC (+)	M 11	M 12	M 13
1.2	DC (+)	M 11	M 12	M 13