

Standards :
 EN ISO 1701 : R FeC-I
 AWS A5.15 : R-CI

UTP 5 UTP Flux 5

Welding rod of the same colour and structure. For grey cast iron.

Application field

UTP 5 is used for oxy-acetylene hot welding of cast iron qualities, when a weld deposit of the same colour and structure is required, e.g. for production welding of new parts (engine blocks, pump housings) and repair welding of stress susceptible cast iron parts. The weld deposit is machinable with cutting tools.

Properties of the weld metal

The weld deposit of UTP 5 is equal in colour and structure as grey cast iron (GJL).

Hardness of the pure weld metal: approx. 200 HB

Weld metal analysis in %

C	Si	Mn	Fe
3,2	3,5	0,6	balance

Welding instruction

Machine welding area to metallic bright, bevel the edges and preheat the casting part right through to 500 – 600° C. Melt the tip of the rod off with neutral flame setting, alloying it with the melting base material. Stir the welding pool by a circular movement of the flame. Slow cooling in an oven or covered with sand or any thermal insulating material.

If additional flux is needed, cover welding area with **UTP Flux 5**, respectively dip hot welding rod into **UTP Flux 5**.

Flame setting

In general neutral, in single cases also oxygen- or acetylene excess in order to avoid porosity.

Availability

Cast blank rods	Ø mm x 500 mm	6,0	8,0	10,0*
Flux (do not paste)	Kg	0,5	-	-

* available on request