

## UTP 68 LC

### Standards :

Material-No. : 1.4316  
 EN 1600 : E 19 9 L R 3 2  
 AWS A5.4 : E 308 L - 17

**Low carbon stick electrode for CrNi steels**

### Application field

The rutile coated stick electrode **UTP 68 LC**, with a low carbon content, is used for joining and building up of identical low carbon, austenitic CrNi steels and CrNi cast steels. Due to the low C-content the deposit is highly resistant to intercrystalline corrosion and can be used for working temperatures up to + 350° C.

### Base materials

1.4301, 1.4306, 1.4311, 1.4312 1.4541

### Welding characteristics and special properties of the weld metal

The stick electrode is weldable in all positions except vertical down. It has a smooth drop transfer and the deposit is finely rippled and without undercut. Slag removal is easy and without residues.

### Mechanical properties of the weld metal

Yield strength R <sub>p0,2</sub> MPa	Tensile strength R <sub>m</sub> MPa	Elongation A %	Impact strength K <sub>v</sub> Joule
> 350	> 520	> 35	> 47

### Weld metal analysis in %

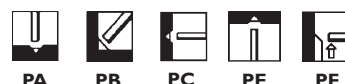
C	Si	Mn	Cr	Ni	Fe
0,025	0,8	0,5	19,0	10,0	balance

### Welding instruction

The stick electrode should be welded slightly inclined and with a short arc. Re-drying 2 hours at 120 – 200° C.

**Current type** DC (+) / AC

**Welding positions**



### Availability / Current adjustments

Stick electrodes	Ø mm x L	2,0 x 300	2,5 x 350	3,2 x 350	4,0 x 350	5,0 x 450
Amperage	A	40 - 60	50 - 90	80 - 120	110 - 160	140 - 200

### Approvals

TÜV (No. 00100), ABS, GL