

## UTP 68

### Standards :

Material-No. : I.4551  
 EN 1600 : E 19 9 Nb R 3 2  
 AWS A5.4 : E 347-17

**Stabilized stick electrode for CrNi-steels**

### Application field

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 clad CrNi steels.

### Base materials

I.4301, I.4312, I.4541, I.4550, I.4552

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

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.

### 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
> 380	> 590	> 30	> 47

### Weld metal analysis in %

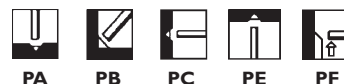
C	Si	Mn	Cr	Ni	Nb	Fe
0,03	0,8	0,5	19,0	10,0	0,25	balance

### Welding instruction

Weld stick electrode slightly inclined 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
Amperage	A	40 – 60	50 – 90	80 – 110	110 – 140

### Approvals

TÜV (No. 02592), ABS, GL