

## UTP 684 MoLC

### Standards :

Material-No. : I.4430  
 EN 1600 : E 19 12 3 LR 15  
 AWS A5.4 : E 316 L-17

**Stick electrode for vertical-down welding of stainless and chemical resistant CrNiMo-steels**

### Application field

**UTP 684 MoLC** is a stick electrode for welding on low-carbon and chemical resistant CrNiMo steels of the same nature in vertical-down position.

### Base materials

I.4401, I.4404, I.4435, I.4436, I.4571, I.4573, I.4580, I.4583

### Properties of the weld metal

The weld deposit of **UTP 684 MoLC** is stainless, IC-resistant (wet corrosion up to 400°C). It is corrosion resistant as similar, low carboned and stabilized, austenitic 18/8 CrNiMo steels.

### 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	> 540	> 25	> 47

### Weld metal analysis in %

C	Si	Mn	Cr	Ni	Mo	Fe
0,025	0,8	0,9	19,0	12,0	2,8	balance

### Welding instruction

Degrease and clean weld area thoroughly (metallic bright). Preheating and post heat treatment are usually not necessary.

### Current type

= +

### Welding positions



PG

### Availability / Current adjustments

Stick electrodes	Ø mm x L	2,5 x 300	3,2 x 300
Amperage	A	75 - 85	105 - 115

### Approvals

TÜV (No. 06726), GL, DNV