

UTP 8 C

Standards :
 EN ISO 1071 : E C Ni-CI I
 AWS A5.15 : E Ni-CI

Cast iron cold-welding stick electrode with graphite lime-type coating and pure nickel core wire

Application field

UTP 8 C is suited for joining and surfacing of all common cast iron qualities, such as grey cast iron GG 10 – GG 40 including alloyed qualities - nodular cast iron GGG 38 – GGG 60 and for all malleable cast iron qualities. It is also suitable for construction and repair welds. A special application field are electrode pickup coatings and buffer layers on alloyed grey cast iron, especially in the tool welding construction if a further weld with UTP 86 FN is continued.

Welding characteristics and special properties of the weld metal

UTP 8 C has a very good, stable arc and good deposition efficiency. Therefore, edge welding is easily possible. The controllable and spatter free flow makes out of position welding possible by using minimum current setting. Slag detachability and weld pattern are excellent.

Mechanical properties of the weld metal

| | |
|-------------------------------------|--------------------|
| Yield strength $R_{p0,2}$ MPa | Hardness HB |
| approx. 220 | approx. 180 |

Weld metal analysis in %

| | | |
|-----|---------|-----|
| C | Ni | Fe |
| 0,9 | balance | 1,0 |

Welding instructions

Remove casting skin in weld area and clean welding spot. The surface has to be examined for cracks and defects. Weld stick electrode with short arc and steep stick electrode guidance. Use a possibly low current setting and weld short stringer weld beads (approx. 50 mm). Peen the weld deposit straight after welding for the purpose of stress relief. Avoid heat concentration in weld area, if necessary, interpass cooling in still air.

Current type DC (-) / AC

Welding positions



Availability / Current adjustment

| | | | | |
|------------------|----------|-----------|-----------|-----------|
| Stick electrodes | Ø mm x L | 2,5 x 300 | 3,2 x 350 | 4,0 x 350 |
| Amperage | A | 70 – 90 | 90 – 130 | 110 – 160 |

Approvals

DB (No. 62.138.06)