

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

UTP 83 FN

Graphite-basic coated ferro-nickel stick electrode with enhanced deposition rate

Application field

UTP 83 FN is suitable for surfacing and joining of all commercial cast iron grades, such as lamellar grey cast iron and nodular cast iron, malleable cast iron and for joining these materials to steel or cast steel. This stick electrode is particularly used where a high deposition rate is needed.

Welding properties

UTP 83 FN has an excellent melting performance and the easily controllable transfer provides a spatter-free deposit of perfect appearance. The weld deposit is easily machinable with cutting tools, tough and crack-resistant.

Hardness of the pure weld metal

approx. 190 HB

Weld metal analysis in %

| C | Ni | Fe |
|-----|------|---------|
| 1,3 | 52,0 | balance |

Welding instruction

The casting skin and impurities have to be removed from the welding area. Weld with low amperage and short arc. For the purpose of stress relief in case of difficult weldings, peen the weld metal and reduce the heat input by welding short beads.

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 | 50 – 70 | 70 – 100 | 100 – 130 |