

UTP A 68 H

Standards :

Material-No. : 1.4842
 EN ISO 14343-A : W/G 25 20
 AWS A5.9 : ~ ER 310 (Si)

Rods and wires for heat and scale resistant CrNi-steels

Application field

UTP A 68 H is suitable for joining and surfacing heat - and scale-resistant 25/20 CrNi-steels and cast steels, such as

Material-No.	DIN		Material-No.	DIN
1.4713	X10 CrAl	7	1.4849	G- X40 NiCrSiNb 38 18
1.4762	X10 CrAl	24	1.4846	X12 CrNi 25 21
1.4845	X12 CrNi	25 21	1.4742	X10 CrAl 18
1.4841	X15 CrNiSi	25 20		

Properties of the weld metal

The weld metal is heat resistant in air and nitrogenous atmosphere at temperatures up to 1100° C, non-resistant to sulphurous combustion gases.

Mechanical properties of the weld metal

Yield strength R _{p0,2} MPa	Tensile strength R _m MPa	Elongation A %	Impact strength K _v Joule
> 400	> 650	> 30	> 60

Weld metal analysis in %

C	Si	Mn	Cr	Ni	Fe
0,12	0,9	3,2	25,0	21,0	balance

Welding instructions

Clean welding area thoroughly. No preheating and post heat treatment. Low heat input. Interpass temperature max. 150° C.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175		Availability	
		M 12	I 1	Spools	Rods
				EN ISO 544	L = 1000mm
1,0	DC (+)	x	x	x	
1,2	DC (+)	x	x	x	
1,6	DC (-)		x		x
2,0	DC (-)		x		x
2,4	DC (-)		x		x
3,2	DC (-)		x		x