

UTP A 68 LC

Standards :

Material-No. : I.4316
 EN ISO 14343-A : G/W 19 9 L
 AWS A5.9 : ER 308 L (Si)

**MIG/MAG gas shielded welding wire
 for CrNi-steels**

Application field

UTP A 68 LC is suitable for joining and surfacing in chem. apparatus and vessel construction for working temperatures of -196°C up to 400°C .

Base materials

I.4301 X5 CrNiNi 18-10
 I.4306 X2 CrNi 19-11
 I.4311 X2 CrNiN 18-10
 I.4312 G-X10 CrNi 18-8
 I.4541 X6 CrNiTi 18-10
 I.4546 X5 CrNiNb 18-10
 I.4550 X6 CrNiNb 18-10
 AISi 304; 304L; 302; 321; 347
 ASTM A 1576 Gr. C 9; A 320 Gr. B 8 C oder D

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	600	35	100

Weld metal analysis in %

C	Si	Mn	Cr	Ni	Fe
0,02	0,4*	1,5	20,0	10,0	balance

* MIG/MAG wire with Si-content of 0,65 - 1,0

Welding procedure and availability

\varnothing (mm)	Current type	Shielding gas EN ISO 14175		Availability	
		I 1	M 12	Spools	Rods
				EN ISO 544	EN ISO 544
0,8	DC (+)		x	x	
1,0	DC (+)		x	x	
1,0 *	DC (-)	x			x
1,2	DC (+)		x	x	
1,2 *	DC (-)	x			x
1,6	DC (-)	x			x
2,0	DC (-)	x			x
2,4	DC (-)	x			x
3,2	DC (-)	x			x

* available on request

Approvals

TÜV (No. 00184; 05831)