

## UTP A 68 MoLC

### Standards :

Material-No. : I.4430  
 EN ISO 14343-A : G/W 19 12 3 L  
 AWS A5.9 : ER 316 L (Si)

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

### Application field

**UTP A 68 MoLC** is used for joining and surfacing of low-carbon, corrosion resistant CrNiMo steels exposed to high corrosion for working temperatures up to + 350° C. Application fields are chemical apparatus and vessels.

### Base materials

Material-No.	EN Symbol
I.4401	X5 CrNiMo 17-12-2
I.4404	X2 CrNiMo 17-12-2
I.4435	X2 CrNiMo 18-14-3
I.4436	X3 CrNiMo 17-13-3
I.4571	X6 CrNiMoTi 17-12-2
I.4580	X6 CrNiMoNb 17-12-2
I.4583	X10 CrNiMoNb 18-12
I.4409	GX2 CrNiMo 19-11-2
	S31653, AISI 316 L, 316 Ti, 316 Cb

### 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
420	600	35	100

### Weld metal analysis in %

C	Si	Mn	Cr	Mo	Ni	Fe
0,02	0,4*	1,5	18,5	2,8	12,0	balance

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

### Welding instruction

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

### Welding procedure and availability

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

### Approvals

TÜV (No. 00188; 05832), GL