UTP A 68

MIG/MAG gas shielded welding wire for CrNi steels

Standards :

Material-No.	:	1.4551
EN ISO 14343-A	:	G/W 19 9 Nb Si
AWS A5.9	:	ER 347 (Si)

Application field

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

Base materials

1.4550	X6 CrNiNb 18-10
1.4541	X6CrNiTi 18-10
1.4552	G-X5 CrNiNb 18-10
1.4311	X2 CrNiN 18-10
1.4306	X2 CrNi 19-11

AISi 347, 321, 302, 304, 3046, 304LN
ASTM A 296 Gr. CF 8 C, A 157 Gr. C 9

Mechanical properties of the weld metal

Yield strength $R_{p0,2}$ MPa	Tensile strength R_m MPa	Elongation A %	Impact strength K_v Joule
420	600	30	100

* 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	
				Spools	Rods
		I 1	M 12	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	
1,6	DC (-)	x			x
2,0	DC (-)	x			x
2,4	DC (-)	x			x
3,2 *	DC (-)	x			x

Approvals

TÜV (No. 04865; 04866)

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