

Standards :

Material-No. : I.4576
 EN I600 : E 19 12 3 Nb R 3 2
 AWSA5.4 : E 318 - 16

Stabilized stick electrode for CrNiMo steels

Application field

The rutile coated stick electrode **UTP 68 Mo** is used for joining and surfacing of stabilized and non stabilized CrNiMo steels and CrNiMo cast steels. The deposit is IC resistant with stabilized base material up to + 400°C working temperature.

Base materials

I.4401, I.4404, I.4408, I.4436, I.4571, I.4580, I.4581, I.4583

Welding characteristics and special properties of the weld metal

The stick electrode is weldable in all positions except vertical down. Even flow, very easy slag removal. Smooth, notch-free seam surface.

Mechanical properties of the weld metal

Yield strength R _{p0,2} MPa	Tensile strength R _m MPa	Elongation A %	Impact strength K _v Joule
380	560	30	55

Weld metal analysis in %

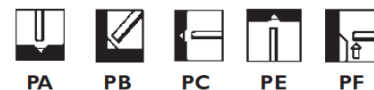
C	Si	Mn	Cr	Mo	Ni	Nb	Fe
0,025	0,8	0,6	18,0	2,7	12,0	0,25	balance

Welding instruction

Clean the weld zone and above all degrease it. Keep a short arc. Weld with dry stick electrodes. Re-dry for 2 h at 120 – 200° C.

Current type DC (+) / AC

Welding positions



Availability / Current adjustments

Stick electrodes	Ø mm x L	1,5 x 250	2,0 x 300	2,5 x 350	3,2 x 350	4,0 x 350	5,0 x 450
Amperage	Ø	25 - 40	40 - 60	50 - 90	80 - 120	120 - 160	140 - 200

Approvals

TÜV (No. 02593)