

## Characteristics and field of use

UTP S 613 Kb is a basic-coated stick electrode for joining on structural steels. Typical usage can be of repairs of structural cracks of excavators, kiln, pulverizing mill, crusher and blast furnace structure. This electrode has special moisture resistant coating.

UTP S 613 Kb has a good weldability and stable arc. The weld metal is resistant to ageing, crack resistant and is little affected by steel impurities.

## Base materials

Construction steels	St 34 – St 60
Fine-grained steels	St E 255 – 355
Boiler steels	H I – H II, 17 Mn 4
Tube steels	St 35 – St 55, St 35.8, St 45.8
Cast steels	GS 38 – GS 52

## Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	Fe
0.04	0.50	0.8	Balance

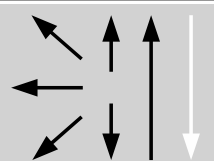
## Mechanical properties of the weld metal

Yield strength $R_{P0.2}$	Tensile strength $R_m$	Elongation A	Impact strength $K_v$
MPa	MPa	%	-30°C (J)
> 420	> 510	> 25	> 35

## Welding instruction

Keep a short arc during the welding process. Weld dry stick electrodes only.  
Re-drying; 2 – 3 h at 250 – 300°C. Preheat Weldment if necessary.

## Welding positions



Current type DC (+) / AC

## Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2.50 x 350	3.20 x 350	4.00 x 350	5.00 x 350
Amperage [A]	80 – 100	110 – 150	140 – 200	170 – 210