UTP S 65 AP

Rutile coated austenitic-ferritic special stick electrode

Classifications		
EN ISO 3581-A	EN 14700	AWS A5.4
~ E 29 9 R 12	E Z Fe11	E312-16 Mod

Characteristics and field of use

- Outstanding weldability, even at low amperage and with AC power. Stable arc, spatter free and excellent slag removal. The finely rippled seam has a homogeneous structure and crack – free seam.
- Ideal for repair & build-up of carbon steels, alloy steels & unknown steels such as gears, cams, shafts, hot cuts, hot trim plates and dies.
- All-purpose application for hard manganese steels, tool steels, spring steels, high speed steels as well as dissimilar metal joints.
- Machinable deposits
- Hardness of the pure weld deposit : Approx. 250 HB

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

C	Si	Mn	Cr	Ni	Fe
0.10	1.20	1.00	30.00	9.50	Balance

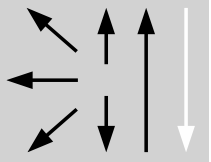
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A
MPa	MPa	%
> 640	> 820	25

Welding instruction

Clean welding area thoroughly. For thick sections and high carbon steel components, preheating temperature to 150 – 200ºC. Weld with short arc and with electrode tilted 10º-15º in direction of travel. Deposit stringer beads, restricting weaving to 2X electrode diameter. Peen welds to relieve stresses. Re-dry electrodes (if necessary) at 200° C for 2 hours.

Welding positions



Current type DC (+) / AC

Approvals

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Size, Packing and Recommended welding parameters

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 350	5.0	20.0	60 – 80
3.25 x 350	5.0	20.0	80 – 130
4.00 x 350	5.0	20.0	110 – 150
5.00 x 350	5.0	20.0	150 – 190