

Classifications

AWS A5.4
E310-16

Characteristics and field of use

UTP S 68H is rutile coated stick electrode for joining and surfacing of heat resistant Cr Steel, CrSi, CrAl, CrNi Steel / Cast Steels. Excellent creep and high temperature corrosion resistance with operational service temperature up to 1100°C. Weld metal microstructure is fully austenite and good hot cracking resistance with proper welding control. Application fields are in the engineering of furnace, pipework and fittings.

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

C	Si	Mn	Cr	Ni	Fe	
0.10	0.65	2.00	26.20	21.80	Balance	

Base materials

G-X30 CrSi 6, X10 CrAl 7, X10 CrAl 24, X15 CrNiSi 20 12, G-X25 CrNiSi 20 14, G-X40 CrNiSi 25 1
 G-X15 CrNi 25 20, X15 CrNiSi 25 20, X12 CrNi 25 21, G-X40 CrNiSi 25 20

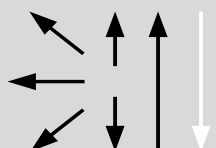
Mechanical properties of the weld metal

Tensile strength	Yield Strength	Elongation	Impact strength	Hardness
[MPa]	[MPa]	[%]	[20°C,J]	[HB]
560	430	35.0	50.0	170

Welding Instruction

Clean welding area. Weld stick electrode with slight tilt and with a short arc. Re-dry stick electrodes 120 - 200°C at 2 hrs.

Welding Position

	Current type DC (+) / AC
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Size, Packing and Recommended welding parameters

Size (mm)	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 350	4.5	18.0	50-75
3.25 x 350	5.0	20.0	70-100
4.00 x 350	5.0	20.0	100-150