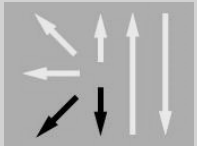


Classifications						
EN ISO 3581-A	AWS A5.4			Material-No.		
E 19 12 3 LR 7 3	E 316 L-26			1.4430		
Characteristics and field of use						
<p>UTP 68 TiMo is a rutile-coated synthetic high performance stick electrode for joining and surfacing on stainless austenitic CrNiMo steels and dissimilar joints of austenitic and ferritic steels.</p> <p>Base materials: 1.4401, 1.4571, 1.4550, 1.4580</p> <p>The weld deposit of UTP 68 TiMo is IC-resistant and has a similar corrosion resistance to low-carbon and stabilized austenitic 18/8 CrNiMo steels.</p>						
Typical analysis in %						
C	Si	Mn	Cr	Ni	Mo	Fe
0.03	0.8	0.6	18.0	12.0	2.6	balance
Mechanical properties of the weld metal						
Yield strength $R_{p0,2}$	Tensile strength R_m		Elongation A		Impact strength K_V	
MPa	MPa		%		J	
370	550		35		50	
Welding instruction						
Clean weld area thoroughly prior welding. Preheating and post-weld heat treatment are usually not necessary.						
Welding positions						
		Current type DC (+) / AC				
Recommended welding parameters						
Electrodes $\varnothing \times L$ [mm]	1.6 x 250	2.0 x 300	2.5 x 350	3.2 x 350	4.0 x 450	
Amperage [A]	40 – 60	50 – 80	70 – 120	110 – 160	140 – 220	
Approvals						
TÜV (No. 00099)						