

Classifications

Material-no.	EN ISO 3581-A	AWS A 5.4
~ 1.4519	E 20 25 5 Cu N L R 3 2	~ E 385-16

Characteristics and field of use

UTP 1925 is a rutile basic-coated stick electrode for joining and surfacing on stainless steels and cast steels with high corrosion resistance to reducing media.

Typical base materials:

- 1.4500
- 1.4505
- 1.4506
- 1.4539

The weld metal of UTP 1925 is stainless and resistant to intergranular corrosion up to 350°C. Good corrosion properties in reducing atmospheres.

Typical analysis in %

C	Si	Mn	Cr	Mo	Ni	Cu	Fe
0.025	0.8	1.5	20.0	4.5	25.0	1.5	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
400	580	30	70

Welding instruction

Degrease and clean weld area thoroughly (metallic bright).
Preheating and post weld heat treatment are usually not necessary.

Welding positions



Approvals

TÜV (No. 04186)

Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 450
Amperage [A]	50 - 70	70 - 110	90 - 140	140 - 190