

## Classifications

EN ISO 3581-A	AWS A5.4	Material-No.
E 19 9 L R 3 2	E 308 L - 17	1.4316

## Characteristics and field of use

The rutile coated stick electrode UTP 68 LC, with a low carbon content, is used for joining and building up of identical low carbon, austenitic CrNi steels and CrNi cast steels. Due to the low C-content the deposit is highly resistant to intercrystalline corrosion and can be used for working temperatures up to +350° C.

The stick electrode is weldable in all positions except vertical down. It has a smooth drop transfer and the deposit is finely rippled and without undercut. Slag removal is easy and without residues.

## Base materials

1.4301, 1.4306, 1.4311, 1.4312, 1.4541

## Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0,025	0,8	0,5	19,0	10,0	balance

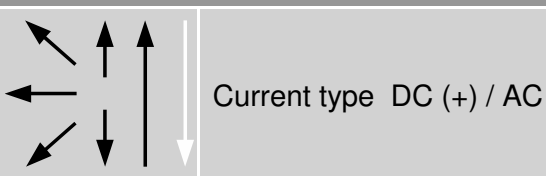
## Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength $R_m$	Elongation A	Impact strength $K_v$
MPa	MPa	%	J
> 350	> 520	> 35	> 47

## Welding instruction

The stick electrode should be welded slightly inclined and with a short arc.  
Redrying 2 hours at 120 – 200° C.

## Welding positions



## Approvals

TÜV (No. 00100), ABS, GL

## Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2,0 x 300	2,5 x 350	3,2 x 350	4,0 x 350	5,0 x 450
Amperage [A]	40 – 60	50 – 90	80 – 120	110 – 160	140 – 200