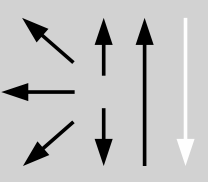


Classifications							
EN ISO 3581-A				AWS A5.4			
E 25 9 4 N L B 42				E 2594-15			
Characteristics and field of use							
<p>UTP 6810 MoKb is a basic-coated low-carbon stick electrode for joining and surfacing on highly corrosion-resistant steels and cast steels with austenitic-ferritic structure (super duplex steels). The weld deposit has a very good resistance to high chloride containing media.</p>							
Base materials							
1.4460, 1.4463, 1.4468, 1.4469							
Typical analysis in %							
C	Si	Mn	Cr	Mo	Ni	N	Fe
0.03	0.55	1.5	25.5	4.3	9.5	0.25	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	
720		850		22		+20°C: > 41 -50°C: > 26	
Welding properties							
<p>UTP 6810 MoKb is weldable in all positions except vertical-down. Fine droplet transfer. The weld seam is regular and finely rippled, easy slag removal.</p>							
Welding instruction							
<p>Weld the stick electrode slightly inclined with a short arc. Thick-walled parts should be slightly preheated, interpass temperature should not exceed 100°C. Re-drying 2-3 h at 250-300°C.</p>							
Welding positions							
		Current type DC (+)					
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 – 75	70 – 110	90 – 150	130 - 200			
* available on request							