

Classifications						
EN ISO 1071		AWS A5.15				
E C NiFe-13		E NiFe-C1				
Characteristics and typical fields of application						
<p>UTP GNX HD is suitable for repair, construction and cladding of several cast iron, especially spheroidal graphite cast iron GJS 40 up to GJS 70, grey iron GJL 18 up to GJL 25 and dissimilar joints with steel. Good alloying properties also at old cast iron.</p> <p>Good and easy welding characteristics at a high deposition rate. Spatter free smooth weld bath. High current rating due to bi metal core wire.</p>						
Base materials						
Spheroidal graphite cast iron GJS 40 up to GJS 70, grey iron GJL 18 up to GJL 25						
Typical analysis of all-weld metal (wt.-%)						
	C	Ni	Fe			
wt.-%	1.1	bal.	45.0			
Mechanical properties of all-weld metal						
Yield strength $R_{p0,2}$		Hardness				
MPa		HB				
~ 340		ca. 220				
Operating data						
	Polarity DC (+) AC	Re-drying: 2 h/300 °C	Electrode identification: UTP GNX HD E C NiFe-13	ø (mm) 2,5 3,2 4,0	L mm 300 350 350	Amps A 60 – 90 90 – 120 110 – 150
<p>Welding instruction: Clean the casting skin at the welding area. Stick electrode should be welded with a steep angle on a short arc.</p> <p>Steady welding with a low heat input using lower amperage. Avoid heat concentration. For stress related parts weld short seams (~ 30 mm). These seams should be well hammered.</p>						
Approvals						
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