UTP 683 LC

Low-carbon high efficiency stick electrode
for CrNiMo steels

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

UTP 683 LC 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.

Base materials: 1.4401, 1.4571, 1.4550, 1.4580

The weld deposit of UTP 683 LC is IC-resistant in welded joints with austenitic CrNiMo steels. UTP 683 LC has excellent welding properties. Smooth and notch free surfaces. Slag removal is easily and without residues. Electrode recovery: 180%

Typical analysis in %

C	Si	Mn	Cr	Ni	Mo	Fe
0.02	0.6	0.6	19.0	12.0	2.6	balance

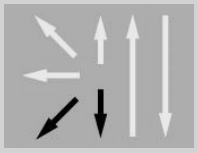
Mechanical properties of the weld metal

Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
370	550	35	50

Welding instruction

Hold electrode as vertically as possible and weld with short arc. Re-dry electrodes for 2h/250 - 350°C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2.0 x 300	2.5 x 350	3.2 x 350	4.0 x 450
Amperage [A]	50 – 80	70 – 120	110 – 160	140 – 220

Approvals

DB (No. 30.138.02)

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.