UTP AF 68 MoLC PW

gas shielded flux cored wire

Classifications

EN ISO 17633-A	AWS A5.22
T 19 12 3 L P M21 1 / T 19 12 3 L P C1 1	E316LT1-4 / E316LT1-1

Characteristics and field of use

UTP AF 68 MoLC PW is a strip alloyed flux cored wire with a rutile slag characteristic for position welding of austenitic CrNiMo steels. The support provided by the fast-hardening slag allows out-ofposition welding with high current magnitudes and high welding speeds. The fine droplet, low-spatter, very powerfully welding spray arc, the reliable fusion penetration, the self-releasing slag and the effectively wetting seam formation result in a high weld quality at the same time as short welding times. Additional advantages to its application result from the ease of handling, the low heat input due to the high welding speed, and the small amounts of cleaning and pickling required. UTP AF 68 MoLC PW is preferred for flat and horizontal welding positions (PA, PB). The weld metal is cryogenic down to -120 °C and resists intergranular corrosion up to +400 °C.

Base materials

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-13-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12, 1.4409 GX2CrNiMo 19-11-2, UNS S31603, S31653; AISI 316L, 316Ti, 316Cb

Typical analysis in %

C	Si	Mn	Cr	Ni	Mo
0,03	0,7	1,5	19,0	12,0	2,7

Mechanical properties of the weld metal

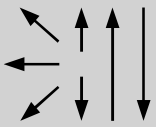
Welded condition	Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V	
	MPa	MPa	%	J [RT]	– 120 °C
untreated	400	560	38	65	45

shielding gas Ar + 18% CO_2

Welding instruction

Welding with conventional MAG devices, slightly trailing torch position (angle of incidence about 80 °), slight weaving of the torch is recommended in all positions. With 100% CO_2 the voltage must be raised by 2 V. The gas quantity should be 15-18 l/min.

Welding positions



Current type DC (+)
Shielding gases: M1 – M3, C1

Approvals

TÜV (09118.), DB (43.014.24), CWB (E316LT1-1(4)), LR (DXV and O, BF 316LS), GL (4571S (C1,M21)), SEPROZ, CE, DNV

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.

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Recommended welding parameters		
Wire diameter [mm]	Amperage [A]	Voltage [V]
1,2	100-220	20-31
1,6	175-260	21-29

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