UTP AF 68 MoLC

gas shielded flux cored wire

Classifications

EN ISO 17633-A	AWS A5.22	Material-No.
T 19 12 3 L RM3 T 19 12 3 L RC3	E 316 LT0-1 E 316 LT0-4	1.4430

Characteristics and field of use

UTP AF 68 LC is a low carbon, CrNi flux-cored wire with rutile slag for joining and surfacing of CrNisteels and cast steel.

The weld metal shows sufficient grain stability up to 350° C and is scaling resistant up to 800° C.

Base materials

Material-No.	AISI	UNS	EN
1.4401	316	S31600	X5 CrNiMo 17-12-2
1.4404	316L	S31603	X2 CrNiMo 17-12-2
1.4406	316LN	S31653	X2 CrNiMoN 17-12-2
1.4571	316Ti	S31635	X6 CrNiMoTi 17-12-2
1.4583	318	S31640	X10 CrNiMoNb 18-12

Typical analysis in %

C	Si	Mn	Cr	Mo	Ni	Fe
0,025	0,6	1,5	19,5	2,7	12,5	balance

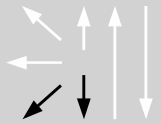
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J [RT]
400	560	35	55

Welding instruction

Clean weld area thoroughly. Welding torch should be held slightly inclined, using the pushing technique. Possibly weaving.

Welding positions



Current type DC (+)
Shielding gases: M21, C1

Approvals

TÜV (No. 06366)

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]
0,9*	100-160	21-30
1,2	125-260	20-34
1,6*	200-300	25-35

*available on request

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.