UTP AF 6824 LC

gas shielded flux cored wire

Classifications

EN ISO 17633-A	ASME II C SFA 5.22	Material-No.
T 23 12 L RM3 T 23 12 L RC3	E 309 LT 0-1 E 309 LT 0-4	1.4332

Characteristics and field of use

UTP AF 6824 LC is a low-carbon flux-cored wire with rutile slag used for joint-welding of alloyed CrNi steels among each other or with other unalloyed or low alloyed steels / cast steels. (b+w joining).

Properties of the weld metal 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 Symbol
1.4301	304	S 30400	X5 CrNi 18 10
1.4306	304 L	S 30403	X2 CrNi 19 11
1.4311	304 LN	S 30453	X2 CrNiN 18 10
1.4401	316	S 31600	X5 CrNiMo 17 12 2
1.4404	316 L	S 31603	X2 CrNiMo 17 13 2
1.4541	308	S 30800	X6 CrNiTi 18 10
1.4550	347	S 34700	X6 CrNiNb 18 10
1.4571	316 Ti	S 31635	X6 CrNiMoTi 17 12 2
1.4583	318	S 31640	G-X5 CrNiNb 19 11

Joining these materials with unalloyed and low-alloyed steels is possible.

Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0,025	0,6	1,5	24,0	12,0	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	550	35	60

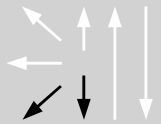
Welding instruction

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

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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Welding positions	
	Current type DC (+) Shielding gases: C1, M20, M21

Approvals
TÜV (No. 06364)

Recommended welding parameters		
Wire diameter [mm]	Amperage [A]	Voltage [V]
0,9*	100-160	21-30
1,2	125-280	20-34
1,6*	200-350	25-35
*available on request		

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