UTP S 68 LC

Low carbon stick electrode for CrNi steels

Classifications	
EN ISO 3581-A	AWS A5.4
E 19 9 L R 3 2	E308L-17

Characteristics and field of use

Rutile electrode with low carbon content and is noted for its superior welding characteristic and metallurgy. Other characteristic include high current carrying capacity, minimum spatter formation, self-releasing slag, smooth and clean weld profile, safety against formation of porosity due to moisture resistant coating and packaging into hermetically sealed tins.

Base materials

1.4301, 1.4306, 1.4311, 1.4312, 1.4541

Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	Cr	Ni	Mo	Fe
0.027	0.79	0.62	19.3	9.7	0.03	Balance

Ferrite Number ≈ 3 – 8 FN WRC 92

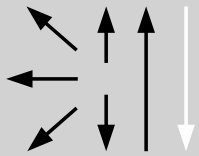
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V (J)	
MPa	MPa	%	+ 20°C	-120°C
425	580	40	59	44

Welding instruction

The stick electrode should be welded slightly inclined and with a short arc. Re-drying 2 hours at 120 – 200°C.

Welding positions



Current type DC (+) / AC

Approvals

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Size, Packing and Recommended welding parameters

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 350	4.10	12.30	45-70
3.25 x 350	4.10	12.30	60-110
4.00 x 450	5.40	16.20	90-150
5.00 x 450	5.40	16.20	150-200

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.