UTP S 68 MoLC

Low carbon stick electrode for CrNiMo steels

Classifications	
EN ISO 3581-A	AWS A5.4
E 19 12 3 L R 3 2	E316L-17

Characteristics and field of use

The rutile electrode with low C content preferably used for austenitic Cr-Ni-Mo steel grades noted for superior welding characteristics and metallurgy. Advantages include high current capacity, minimum spatter formation, easy slag removal, smooth and clean weld, safety against formation of porosity due to moisture resistant coating and packaging into hermetically sealed tins.

Base materials

1.4401, 1.4404, 1.4436, 1.4571, 1.4573, 1.4580, 1.4583

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

C	Si	Mn	Cr	Ni	Mo	Fe
0.10	0.50	5.5	19.5	8.5	2.6	Balance

Ferrite Number ≈ 3 – 8 FN WRC 92

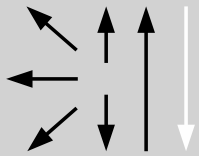
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V (J)	
MPa	MPa	%	+ 20°C	-120°C
470	590	40	57	38

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.