UTP S 6808 Mo

Rutile-basic coated stick electrode for duplex steels

Classifications	
EN ISO 3581-A	AWS A5.4
E 22 9 3 N LR 3 2	E2209-17

Characteristics and field of use

UTP S 68080 Mo is a rutile basic coated stick electrode for joining and surfacing on corrosion resistant steels / cast steels with an austenitic-ferritic structure (Duplex Steels). The deposit is highly resistant to pitting, gap- and stress corrosion in chloride containing media. Applicable in temperatures up to 250°C.

UTP S 68008 Mo is weldable in all position except vertical down. Stable arc, very good slag removal, finely rippled and a notch free weld seem.

Base materials

1.4347, 1.4460, 1.4462, 1.4463

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

C	Si	Mn	Cr	Ni	Mo	N
0.025	0.8	0.7	23	9.5	2.90	0.15

Ferrite Number ≈ 50 FN WRC 92

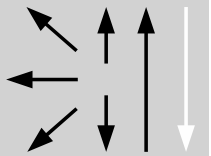
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V (J)	
MPa	MPa	%	+ 20°C	-40°C
600	800	26	38	31

Welding instruction

Weld stick electrode slightly inclined and with short arc. Thick walled materials have to be preheated to 100°C. Re-drying 2 h at 250-350°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)
2.50x350	4.10	12.30	45 – 80
3.25×350	4.10	12.30	70 – 120
4.00×450	5.40	16.20	90 – 160
5.00×450	5.40	16.20	150 – 220

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.