UTP S 6824 LC

Low carbon CrNi-stick electrode for dissimilar metal joints and claddings

Classifications

EN ISO 3581-A	AWS A5.4
E 23 12 L R 32	E309L-17

Characteristics and field of use

Rutile coated for dissimilar joint welds and surfacing. It can be used for DC and AC.

Other advantages include high current carrying capacity, minimum spatter, easy slag removing, smooth and clean weld profile. Deposits are scale resistant up to 1000°C.

Base materials

1.4541, 1.4550, 1.4583, 1.4712, 1.4724, 1.4742, 1.4825, 1.4826, 1.4828

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

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

C	Si	Mn	Cr	Ni	Fe
0.023	0.74	0.74	23.6	13.2	Balance

Ferrite Number ≈ 15 FN WRC 92

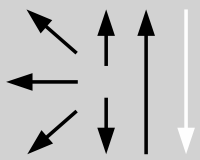
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V (J)	
MPa	MPa	%	+ 20°C	-60°C
> 445	> 565	41	59	46

Welding instruction

Weld the stick electrode slightly inclined with a short arc. For claddings, the pre-heating and interpass temperature should be adjusted according to the base material. 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 300	3.63	10.96	50 – 70
3.25 x 350	4.10	12.30	80 – 120
4.00 x 450	5.40	16.20	100 – 150
5.00 x 450	5.40	16.20	160 – 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.