UTP 2949 W

basic coated special stick electrode with high carbon content

Classifications	
EN ISO 14172	Material-No.
E Ni 8025 (mod.)	2.4879

Characteristics and field of use

UTP 2949 W is suitable for joining and surfacing high alloyed 28/48 CrNi high temperature cast materials of identical or similar nature, such as material-No. 2.4879 G-NiCr28W.
Main applications are reformer tubes in petrochemical installations with a service temperature up to 1150°C.

UTP 2949 W has a smooth, stable arc. Easy slag removal. The seam has a finely rippled structure. The weld metal is high temperature resistant with very good creep strength.

Typical analysis in %

C	Si	Mn	Cr	Ni	W	Fe
0,45	1,1	1,2	29,0	49,0	4,5	balance

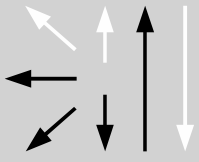
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A
MPa	MPa	%
> 480	> 650	> 5

Welding instruction

Clean welding area. Hold stick electrode as vertically as possible with a short arc. Use string bead welding technique with little weaving. This stick electrode is weldable with low amperage settings. Interpass temperature max. 150° C. Re-dry stick electrodes 2 –3 h / 250 –300° C.

Welding positions



Current type DC (+)

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 300*	3,2 x 350*	4,0 x 350*	5,0 x 400
Amperage [A]	50 – 70	70 – 120	100 – 140	-

*available on request

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.