UTP 611

Rutile, thick-coated stick electrode, universally applicable

Classifications	
EN ISO 2560-A	AWS A5.1
E 42 0 RR 12	E 6013

Characteristics and field of use

UTP 611 is a thick-coated stick electrode for joining and surfacing on all kinds of mild steel constructions. It is used in automotive- and wagon industries, boiler construction and shipbuilding.

UTP 611 is easily weldable in all positions except for vertical down. It shows excellent welding properties: very easy slag removal and a smooth and finely-rippled weld seam surface.
The stick electrode can be applied within a wide amperage range.

Base materials

Construction steel St 34 - St 52
Boiler steels H I - H II, WStE 255, 17 Mn 4
Tube steels St 35 , St 45, St 35.8, St 45.8, StE 210.7 - StE 360.7

Typical analysis in %

C	Si	Mn	Fe
0.10	0.3	0.5	balance

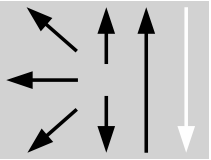
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
> 420	> 510	> 17	> 47

Welding instruction

UTP 611 is welded with a short to medium-long arc with slight weaving.
The stick electrode should be held at an angle of approx. 75° to the plate.
Re-drying: 2 – 3 h at 250 – 300°C.

Welding positions



Current type DC (–) / AC

Approvals

TÜV (No. 02180), DB (No. 10.132.79), DNV

Recommended welding parameters

Electrodes Ø x L [mm]	2.0 x 300	2.5 x 350	3.2 x 350	3.2 x 450	4.0 x 450	5.0 x 450
Amperage [A]	40 – 70	60 – 90	90 – 140	90 – 140	140 – 190	190 – 230

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.