UTP 613 Kb

basic-coated stick electrode

Classifications	
EN ISO 2560-A	AWS A5.1
E 42 5 B42 H5	~ E 7018-1 H4 R

Characteristics and field of use

UTP 613 Kb is a basic-coated stick electrode for construction-, boiler-, tube- and fine-grained steels as well as for steels with up to 0.35% C-content. It is especially recommended for the base materials as mentioned below.

UTP 613 Kb has a good weldability and a stable arc. The weld metal is resistant to ageing, crack-resistant and is little affected by steel impurities.

Base materials

Construction steels	St 34 - St 60
Fine-grained-steels	St E 255 - 355
Boiler steels	H I - H II, 17 Mn 4
Tube steels	St 35 - St 55, St 35.8, St 45.8
Cast steels	GS 38 - GS 52

Typical analysis in %

C	Si	Mn	Fe
0.07	0.4	1.1	balance

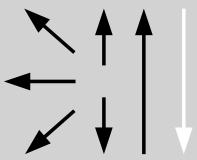
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
> 420	> 510	> 25	> 120

Welding instruction

Keep a short arc during the welding process. Weld dry stick electrodes only.
Re-drying: 2 – 3 h at 250 – 300° C. Preheat weldment if necessary.

Welding positions



Current type DC (+)

Approvals

TÜV (No. 00794), DB (No. 10.014.80), ABS, BV, DNV

Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350	5.0 x 450
Amperage [A]	80 – 100	110 – 150	140 – 200	170 – 210

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.