UTP 86 FN

Graphite-basic coated FeNi stick electrode

Classifications

AWS A5.15 / SFA-5.15	EN ISO 1071
ENiFe-CI	E C NiFe-13

Characteristics and typical fields of application

UTP 86 FN is suitable for joining and surfacing of lamellar grey cast iron EN GJL 100 - EN GJL 400, nodular cast iron (spheroidal cast iron) EN GJS 400 - EN GJS 700 and malleable cast iron grades EN GJMB 350 - EN GJMB 650 as well as for joining these materials with each other or with steel and cast steel. Universally applicable for repair, construction and production welding.

UTP 86 FN has excellent buttering characteristics on cast iron. The stick electrode has a stable arc and produces a flat seam structure without undercutting. Particularly for fillet welds an optimal seam structure is achieved (e.g. welding GJS-flanges or sockets to GJS-tubes). Due to the bimetallic core wire, the current carrying capacity and the deposition rate are excellent. The bead appearance is smooth. The weld deposit is highly crack resistant and easily machinable with cutting tools.

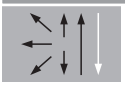
Typical analysis

	C	Ni	Fe
wt.-%	1.2	bal.	45.0

Mechanical properties of all-weld metal - typical values (min. values)

Yield strength $R_{p0.2}$	Hardness
MPa	HB
ca. 340	ca. 220

Operating data



Polarity	DC – / AC

Dimension mm	Current A
2.5 × 300	60-90
3.2 × 350	90-140
4.0 × 350	100-170

Welding instructions

UTP 86 FN is preferably welded on DC (negative polarity) or on AC. Welding on DC (negative polarity) generates flat and notch-free weld beads. Positional weldings are easier with AC. Prior to welding, remove the casting skin. Hold stick electrode vertically and with short arc. When welding crack-susceptible cast iron grades, the deposit may be peened for the purpose of stress relief.

Approvals

DB (Nr. 62.138.05)

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.