UTP 8

Graphite-basic coated stick electrode for cold welding of cast iron

Classifications

AWS A5.15 / SFA-5.15	EN ISO 1071
ENi-CI	E C Ni-CI 1

Characteristics and typical fields of application

UTP 8 is for cold welding of grey and malleable cast iron, cast steel and for joining these base metals to steel, copper and copper alloys, especially for repair and maintenance.

UTP 8 has excellent welding properties. The easily controllable flow permits spatterfree welding in all positions and with minimal amperage. The weld deposit and the transition zones are filable. No undercutting. Ideally suited for the combined welding with the ferronickel type UTP 86 FN (buttering with UTP 8 and filling with UTP 86 FN).

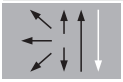
Typical analysis

	C	Ni	Fe
wt.-%	1.2	bal.	1.0

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

Yield strength $R_{p0.2}$	Hardness
MPa	HB
220	180

Operating data



Polarity	DC – / AC

Dimension mm	Current A
2.0 × 300	45 - 60
2.5 × 300	60 - 80
3.2 × 350	80 - 130
4.0 × 350	110 - 140

Welding instructions

Depending on the wall thickness, the preparation is made in U- or double U-form. The casting skin has to be removed on both sides of the welding area. Hold the stick electrode vertically with a short arc. Thin passes are buttered, their width not more than twice the diameter of the core wire. To avoid over-heating, the beads should not be longer than 10 times the stick electrode diameter. Remove the slag immediately after welding and then peen the deposit carefully. Reignite on the weld deposit and not on the base metal.

Approvals

DB (No. 62.138.01)

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.