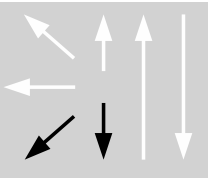


Classifications					
EN ISO 3581-A	AWS A5.4			Material-No.	
E 18 8 Mn R 73	E307-26 (mod.)			1.4370	
Characteristics and field of use					
<p>UTP 630 is suited for particularly tough, crack resistant joints and surfacings on high strength steels, hard-manganese steels and heterogeneous joints. Suitable for surfacings on parts subjected to impact, pressure and rolling wear, such as rails, curved rails, switches, rolls etc. and for tough buffer layers under hard alloys. A main application field is for repair and maintenance in the constructional industry.</p> <p>UTP 630 is easily weldable with stable arc, homogeneous, finely rippled bead appearance and gives good slag removal. The fully austenitic weld metal is resistant to corrosion and to scale up to 850°C. The weld metal is work-hardenable.</p> <p>Hardness of the pure weld metal</p> <p>untreated: approx. 200 HB work-hardened: approx. 350 HB</p>					
Typical analysis in %					
C	Si	Mn	Cr	Ni	Fe
0.1	0.8	6.0	19.0	9.0	balance
Mechanical properties of the weld metal					
Yield strength $R_{p0,2}$		Tensile strength R_m		Elongation A	
MPa		MPa		%	
350		600		40	
				Impact strength K_v	
				J	
				> 60	
Welding instruction					
<p>Clean welding area thoroughly. Pre-heating of thick-walled ferritic parts to 150 - 250°C. Hold stick electrode vertically with a short arc. Re-dry stick electrodes that have got damp for 2 h / 250 - 300°C.</p>					
Welding positions					
 <p>Current type DC (+) / AC</p>					
Recommended welding parameters					
Electrodes $\varnothing \times L$ [mm]	2.5 x 350	3.2 x 450	4.0 x 450	5.0 x 450	
Amperage [A]	80 – 100	100 – 130	130 – 180	150 – 200	