UTP 8 — cast iron

Classifications	graphite-basic-coated stick electrode
EN ISO 1071	AWS A5.15
E C Ni-CI 1	E Ni-CI

Characteristics and field of use

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 ferro-nickel type UTP 86 FN (buttering with UTP 8 and filling with UTP 86 FN).

Typical analysis in %

C	Ni	Fe
1.2	balance	1.0

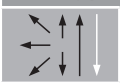
Mechanical properties of the weld metal

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

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.

Welding positions



Current type DC (–) / AC

Approvals

DB (No. 62.138.01)

Form of delivery and recommended welding parameters

Electrodes Ø x L [mm]	2.0 x 300	2.5 x 300	3.2 x 350	4.0 x 350
Amperage [A]	45 – 60	60 – 80	80 – 100	110 – 140