

## Characteristics and field of use

The strongly coated chamfering stick electrode UTP 82 AS can be used on all steel grades with ferritic and austenitic structure, as well as cast iron, cast steel and all non-ferrous metals. It enables workpieces to be grooved out in a very simple way. UTP 82 AS is also suitable for removing corroded metal layers and for fusion-cutting metallic materials.

UTP 82 AS strikes easily and generates a high gas pressure, enabling a clean and smooth cut to be achieved.

## Welding instruction

When grooving it is advisable to tilt the plate in the direction of working, so that the molten parent metal can run off better. The stick electrode should be inclined to the parent metal as horizontally as possible (approx. 15 °C) and kept constantly in contact with it. The working speed is increased by slight pushing movements in the direction of working. Parent metal left on the edge of the groove is easily removed with the slag hammer. Machining the groove down to the bare metal may be advisable, depending on the circumstances.

## Current type

DC (-) / AC

## Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 250	3.2 x 350	4.0 x 350	5.0 x 350
Amperage [A]	150 – 250	200 – 300	250 – 400	350 – 500