

UTP 6824 LC

Standards :

Material-No.	:	~ I.4332
EN 1600	:	E 23 12 L R 3 2
AWS A5.4	:	E 309 L-17

Low carbon CrNi-stick electrode for dissimilar metal joints and claddings

Application field

The rutile coated stick electrode **UTP 6824 LC** is used for joining and surfacing of stainless and heat resistant steels / cast steels as well as for dissimilar metal joints (heterogeneous joints) and for buffer layers on corrosion - or wear resistant claddings on C-steels. The weld deposit is scale resistant up to + 1000° C.

Base materials

I.4541, I.4550, I.4583, I.4712, I.4724, I.4742, I.4825, I.4826, I.4828

Joining these materials with unalloyed and low-alloyed steels is possible.

Welding characteristics and special properties of the weld metal

The stick electrode is weldable in all positions except vertical-down. It is distinguished by a stable arc, minimal spatter, and very good slag removal. The weld seam is regularly marked and free of pores.

Mechanical properties of the weld metal

Yield strength $R_{p0,2}$ MPa	Tensile strength R_m MPa	Elongation A %	Impact strength K_v Joule
> 390	> 550	> 30	> 47

Weld metal analysis in %

C	Si	Mn	Cr	Ni	Fe
0,025	0,8	0,8	22,5	12,5	balance

Welding instruction

Weld the stick electrode slightly inclined with a short arc. For claddings, the pre-heating and interpass temperature should be adjusted according to the base material. Re-drying 2 h at 120 – 200° C.

Current type DC (+) / AC

Welding positions



Availability / Current adjustments

Stick electrodes	Ø mm x L	2,5 x 350	3,2 x 350	4,0 x 350	5,0 x 450*
Amperage	A	60 – 80	80 – 110	110 – 140	140 – 180

* available on request

Approvals

TÜV (No. 04074), GL, DNV