

**Standards :**

EN 1600 : E 23 12 2 L R 3 2  
 AWS A5.4 : ~ E 309 MoL-17

## UTP 6824 MoLC

**Low carbon stick electrode for dissimilar metal joints and claddings**

**Application field**

**UTP A 6824 MoLC** is a low-carbon CrNiMo-stick electrode for dissimilar metal joints and claddings on the following base materials.

**Base materials**

I.4401, I.4404, I.4580, I.4571

**Properties of the weld metal**

The weld deposit of **UTP 6824 MoLC** is stainless, IK-resistant (wet corrosion up to 350°C) and is suited for austenitic ferritic joints (maximum application temperature at 300°C).

**Mechanical properties of the weld metal**

Yield strength R <sub>p0,2</sub> MPa	Tensile strength R <sub>m</sub> MPa	Elongation A %	Impact strength K <sub>v</sub> Joule
> 490	> 670	> 25	> 47

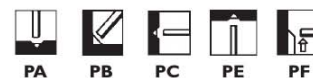
**Weld metal analysis in %**

C	Si	Mn	Cr	Mo	Ni	Fe
0,03	0,8	1,5	23,0	2,8	12,0	balance

**Welding instruction**

Weld area must be thoroughly cleaned and degreased. Preheating and post heat treatment have to be adjusted to the base metal. Re-drying 2 h at 120 - 200° C.

**Current type**

**Welding positions**

**Availability / Current adjustments**

Stick electrodes	Ø mm x L	2,0 x 300	2,5 x 350	3,2 x 350	4,0 x 350
Amperage	A	40 - 60	60 - 80	80 - 120	100 - 160