

## UTP 8I

### Standards :

EN ISO 1071 : E C Z Fe-I  
~AWS A5.15 : E St

**Ferro-based stick electrode for cast iron of poor weldability**

### Application field

**UTP 8I** is especially suited for pickup layers on poorly weldable cast iron (e.g. old cast iron) as a base for a secondary weld with pure nickel or nickel-iron stick electrodes. Wear surfacing can also be performed with a one-pass weld.

### Welding properties and special properties of the weld metal deposit

**UTP 8I** has good welding properties and is welded by applying the stringer bead technique. It has a high deposition efficiency and low penetration. Out of position welding is possible.

### Hardness of the pure weld deposit

approx. 350 HB

### Weld metal analysis in %

C	Si	Mn	Fe
1,0	0,5	0,5	balance

### Welding instruction

Welding area has to be machined to a metallic bright or prepare the welding area by applying the chamfering stick electrode UTP 82 AS to prepare the weld spot. Use a steep stick electrode guidance and a short arc. Avoid heat accumulation and keep the weld interpass temperature to a maximum of 60°C. Additional coating deposit has to be grinded down to the original weld surface in order to continue the weld with UTP 8 C or respectively UTP 86 FN.

**Current type** DC (+) / AC

**Welding positions**



### Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 300*	3,2 x 300	4,0 x 400
Amperage	A	60 – 80	80 – 100	100 – 120

\* available on request