UTP GNX-HD

Graphite-basic-coated ferro-nickel stick electrode
with high mechanical properties

Classifications	
EN ISO 1071	AWS A5.15
E NiFe-13	E NiFe-Cl

Characteristics and field of use

UTP GNX-HD is suited for fabrication and repair welds, as well as for surfacings on all types of cast-iron, esp. cast-iron with nodular graphite GGG 40 to GGG 70, grey cast-iron GG18 to GG 25, and for dissimilar joints with steels. Good wetting behaviour, even on old or poorly weldable cast-iron.

UTP GNX-HD shows excellent welding properties, a stable and spatter-free arc, a smooth flow behaviour and a high efficiency rate. Thanks to the bi-metal core wire, a high current carrying capacity is ensured.

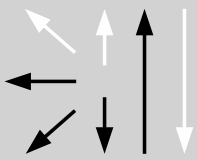
Typical weld metal analysis in %		
C	Ni	Fe
1.1	balance	45.0

Mechanical properties of the weld metal	
Yield strength $R_{p0,2}$	Hardness
MPa	HB
approx. 340	approx. 220

Welding instruction

Remove the outer cast skin in the weld area. The angle between the plate and the electrode should be kept between 80-90°. Weld with short arc. Keep current settings as low as possible, avoid heat accumulation. Cast-iron welds susceptible to stress should be welded in shorts beads (approx. 30 mm) and must be thoroughly hammered.

Welding positions



Current type DC (+) / AC

Recommended welding parameters			
Electrodes Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 350
Amperage [A]	60-90	90-120	110-150