

Classifications

EN ISO 3581-A	AWS A5.4 / SFA-5.4
E 13 4 R 3 3	E 410 NiMo-16

Characteristics and typical fields of application

UTP 6635 Ti is a rutile-coated stick electrode for joinings and surfacings on corrosion resistant soft martensitic CrNi-steels and corresponding cast steels containing 13% Cr and 4% Ni, such as the material 1.4313. The weld deposit has an increased resistance to cavitation and erosion. Welding properties UTP 6635 Ti exhibits an easy slag removal, smooth arc and notch-free welding surface. Recovery: 120%.

Typical analysis


	C	Si	Mn	Cr	Ni	Mo	Fe
wt.-%	0.03	0.3	0.5	12.0	4.5	0.5	bal.

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J
	MPa	MPa	%	20°C
	≥ 650	≥ 800	≥ 10	≥ 25

u untreated, as-welded

Operating data

	Polarity	DC +	Dimension mm	Current A
	Redrying	2 h / 300-350 °C	2.5 × 300	70 – 90
			3.2 × 350	100 – 120
			4.0 × 400	120 – 140

Prior to welding, electrodes should be re-baked for 3 hours at 250-300°C. Interpass temperature for welding of same or similar materials should be in the range of 100-250°C.

Approvals

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