

## Classifications

AWS A5.15 / SFA-5.15

EN ISO 1071

ENiFe-Cl

E C NiFe-1 1

## Characteristics and typical fields of application

UTP 83 FN is suitable for surfacing and joining of all commercial cast iron grades, such as lamellar grey cast iron and nodular cast iron, malleable cast iron and for joining these materials to steel or cast steel. This stick electrode is particularly used where a high deposition rate is needed.

UTP 83 FN has an excellent melting performance and the easily controllable transfer provides a spatterfree deposit of perfect appearance. The weld deposit is easily machinable with cutting tools, tough and crack-resistant.

Hardness of the pure weld metal: approx. 190 HB

## Typical analysis

	C	Ni	Fe
wt.-%	1.3	52.0	bal.

## Operating data

	Polarity	DC + / AC	Dimension mm	Current A	
				2.5 × 300	50 – 70
				3.2 × 350	70 – 100
				4.0 × 350	100 – 130

## Welding instructions

The casting skin and impurities have to be removed from the welding area. Weld with low amperage and short arc. For the purpose of stress relief in case of difficult weldings, peen the weld metal and reduce the heat input by welding short beads.

## Approvals

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