

## Classifications

EN ISO 1071

S C NiFe-2

## Characteristics and field of use

UTP A 8051 Ti is particularly suited for welding of ferritic and austenitic nodular cast iron as well as for joining it with unalloyed and high-alloyed steels, copper and nickel alloys. Build-up layers on grey cast iron qualities are also possible. Special applications are construction welding of ductile centrifugal casting tubes, such as joggles and flange joints, fittings, pumps.

The deposit is tough, crack resistant and easily machinable with cutting tools.

## Typical analysis in %

C	Mn	Ni	Ti	Fe
0,1	3,5	55,0	0,5	balance

## Mechanical properties of the weld metal

Yield strength $R_e$	Tensile strength $R_m$	Elongation $A_5$	Hardness
MPa	MPa	%	HB
> 300	> 500	> 25	approx. 200

## Welding instruction

Machine welding area to metallic bright. Preheat massive cast iron pieces to 150-250° C. Weld preferably with TIG-pulsed arc, in order to reduce the dilution with the base metal.

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
1,6 x 1000*	DC (-)	I 1
2,4 x 1000*	DC (-)	I 1

\*available on request