

## Classifications

EN ISO 3581-A	EN 14700	Material-No.
E 18 8 Mn R 32	E Fe10	1.4370

## Characteristics and typical fields of application

Rutile coated, fully austenitic stick electrode for repair welding of alloyed construction and heat-treated steel. Welding also in combination with austenitic CrNi steels. Furthermore welding of scale-resisting steels for operating temperatures up to 850° C as well as higher carbon materials and high manganese steels, also in combination with other steels. For surfacing on workpieces exposed to impact, pressure and rolling wear, such as curved rails, points, crusher and excavator teeth. Moreover it provides crack-proof buffer layers under hard alloys.

UTP 63 has good welding properties, stable arc, finely rippled bead appearance. The weld deposit resists to scaling, rust and cracks, work-hardened.

Hardness of the pure weld metal  
 untreated: approx. 200 HB  
 work-hardened: approx. 350 H


## Typical analysis

	C	Si	Mn	Cr	Ni	Fe
wt.-%	0.1	0.5	5.5	19.0	8.5	bal.

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

Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J
MPa	MPa	%	J
>350	>600	>40	>60

## Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	2 h / 250-350 °C	2.5 × 250	50-70
		3.2 × 350	70-100	
		4.0 × 400	100-130	
		5.0 × 450	150-180	

## Welding instructions

Clean welding area thoroughly. Preheating of thick-walled ferritic parts to 150 – 250° C. Hold stick electrode vertically with a short arc. Redry stick electrodes that have got damp for 2 h / 250 – 300° C.

## Approvals

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