

## Classifications

EN ISO 3581-A	AWS A5.4 / SFA-5.4	Material-No.
E 19 12 3 L R 7 3	E316L-26	1.4430

## Characteristics and typical fields of application

UTP 68 TiMo is a rutile-coated synthetic high performance stick electrode for joining and surfacing on stainless austenitic CrNiMo steels and dissimilar joints of austenitic and ferritic steels.

The weld deposit of UTP 68 TiMo is IC-resistant and has a similar corrosion resistance to low-carbon and stabilized austenitic 18/8 CrNiMo steels.

## Base materials

1.4401, 1.4571, 1.4550, 1.4580

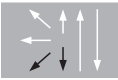
## Typical analysis

	C	Si	Mn	Cr	Ni	Mo	Fe
wt.-%	0.03	0.8	0.6	18.0	12.0	2.6	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	A	J
370	550	35	50

## Operating data

	Polarity	DC + / AC	Dimension mm	Current A	
				1.6 × 250	40 – 60
				2.0 × 300	50 – 80
				2.5 × 350	70 – 120
				3.2 × 350	110 – 160
				4.0 × 450	140 – 220

Clean weld area thoroughly prior welding. Preheating and post-weld heat treatment are usually not necessary.

## Approvals

TÜV (No. 00099)