

## Classifications

<b>EN ISO 3581-A</b>	<b>AWS A5.4 / SFA-5.4</b>
E 19 12 3 L R 73	E316L-26

## Characteristics and typical fields of application

UTP 683 LC is a rutile coated, synthetic high performance stick electrode for joining and surfacing of stainless austenitic CrNiMo steels and dissimilar joints of austenitic and ferritic steels.

The weld deposit of UTP 683 LC is IC-resistant in welded joints with austenitic CrNiMo steels. UTP 683 LC has excellent welding properties. Smooth and notch free surfaces. Slag removal is easily and without residues.

Electrode recovery: 180%

## Base materials

1.4401, 1.4571, 1.4550, 1.4580


## Typical analysis

	C	Si	Mn	Cr	Ni	Mo	Fe
wt.-%	0.02	0.6	0.6	19.0	12.0	2.6	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
aw	370	550	35	50

## Operating data

	Polarity	DC (+) / AC	Dimension mm	Current A
	Redrying	250 - 350°C / 2h		2.0 × 300
			2.5 × 350	70 - 120
			3.2 × 350	110 - 160
			4.0 × 450	140 - 220

Hold electrode as vertically as possible and weld with short arc.

## Approvals

DB (30.138.02)