

Covered electrodes for repair of cracked material

Unalloyed and low alloy steels

Product Name Classification AWS Classification EN Classification DIN	Mechanical Properties Typical Values	Size (mm)	Approvals	Characteristics and Applications
UTP 613 kb AWS A5.1: ~ E 7018-1 H4-R EN ISO 2560-A: E 42 5 B42 H5	UTS: >510 MPa YS: >420 MPa EI: >25% CVN Impact: >120J	2.5 x 350 3.2 x 350 4.0 x 350 5.0 x 450	TÜV, DB, ABS, BV, DNV	UTP 613 Kb is a basic-coated stick electrode for construction-, boiler-, tube- and fine-grained steels as well as for steels with up to 0.35% C-content. UTP 613 Kb has a good weldability and a stable arc. The weld metal is resistant to ageing, crack-resistant and is little affected by steel impurities.
LOTUS - 24	UTS: 520 - 600 MPa EI: 25 - 32% CVN Impact: 27°C: 190J	2.50 x 350 3.15 x 350 4.0 x 350 5.0 x 350	-	High strength welds deposit and minimum distortion. Smooth weld bead of X- ray quality. Weld bead with fine ripples and easy slag removal. Suitable for low & medium carbon steels. Excellent mechanical properties including impact strength. Applications: Flanges, crane girders, shovel boom, dumper chassis and heavy equipment maintenance.

Stainless Steels

Product Name Classification AWS Classification EN Classification DIN	Mechanical Properties Typical Values	Size (mm)	Approvals	Characteristics and Applications
UTP S 63 AWS A5.4: E307-16 EN ISO 3581-A: E 18 8 Mn R 32	UTS: >600 MPa YS: >350 MPa EI: >40% CVN Impact: +20°C: 60J	2.50 x 350 3.25 x 350 4.00 x 350 5.00 x 450	-	Non alloy structural and heat treatable steels can be welded, also in combination with austenitic CrNi steels. Universally applicable for surfacing of work pieces exposed to impact, pressure and rolling wear. Such as curved rails, crusher parts, and excavator teeth. Provides crack-proof buffer layers under hard alloys. Weld deposit resist to scaling, rust and cracks, work hardened. Hardness of the pure weld metal As welded: 190 HB After work hardened: 250 HB
UTP 65 D EN ISO 3581-A: E Z 29 9 R 12 EN 14700: E Z Fe11	UTS: >800 MPa YS: >640 MPa EI: >20%	1.6 x 250* 2.0 x 250 2.5 x 250 3.2 x 350 4.0 x 350 5.0 x 350 * available on request	-	UTP 65 D has been developed to meet the highest requirements for repair and surfacing. It is extremely crack-resistant when joining steels of difficult weldability, such as e. g. hard manganese steels, tool steels, spring steels, high speed steels as well as dissimilar metal joints. Due to the good corrosion and abrasion resistance and high tensile strength. UTP 65 D finds its application particularly in repair and maintenance of machine and drive components, such as gears, cams, shafts, hot cuts, hot trim plates and dies. Also ideally suited as an elastic cushioning layer for very hard surfacings.

