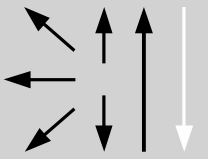


Classifications				
EN ISO 1071		AWS A5.15		
E C Ni-CI 1		ENi-CI		
Characteristics and field of use				
<p>UTP 8 is for cold welding of grey and malleable cast iron, cast steel and for joining these base metals to steel, copper and copper alloys, especially for repair and maintenance.</p> <p>UTP 8 has excellent welding properties. The easily controllable flow permits spatterfree welding in all positions and with minimal amperage. The weld deposit and the transition zones are filable. No undercutting. Ideally suited for the combined welding with the ferro-nickel type UTP 86 FN (buttering with UTP 8 and filling with UTP 86 FN).</p>				
Typical analysis in %				
C	Ni	Fe		
1.2	balance	3.6		
Mechanical properties of the weld metal				
Yield strength $R_{P0,2}$		Hardness		
MPa		HB		
approx. 220		approx. 180		
Welding instruction				
<p>Depending on the wall thickness, the preparation is made in U- or double U-form. The casting skin has to be removed on both sides of the welding area. Hold the stick electrode vertically with a short arc. Thin passes are buttered, their width not more than twice the diameter of the core wire. To avoid over-heating, the beads should not be longer than 10 times the stick electrode diameter. Remove the slag immediately after welding and then peen the deposit carefully. Reignite on the weld deposit and not on the base metal.</p>				
Welding positions				
		Current type DC (-) / AC		
Approvals				
DB (No. 62.138.01)				
Recommended welding parameters				
Electrodes $\varnothing \times L$ [mm]	2,0 x 300	2,5 x 300	3,2 x 350	4,0 x 350
Amperage [A]	45 – 60	60 – 80	80 – 100	110 – 140