

Classifications

EN ISO 2560-A	AWS A5.1
E 38 0 RR 12	~ E 6013

Characteristics and field of use

UTP 611 is a strongly coated stick electrode for joining and surfacing on all kind of steel constructions. It is used in autobody- and wagon industry, boiler construction and shipbuilding.

UTP 611 is very easy weldable in all positions except vertical down. It possesses excellent welding properties. Very easy slag removal. Smooth, finely rippled weld seam surface. The stick electrode can be applied within a wide amperage range.

Base materials

Construction steel St 34 - St 52
 Boiler steels H I - H II, WStE 255, 17 Mn 4
 Tube steels St 35 , St 45, St 35.8, St 45.8, StE 210.7 - StE 360.7

Typical analysis in %

C	Si	Mn	Fe
0,07	0,5	0,6	balance

Mechanical properties of the weld metal

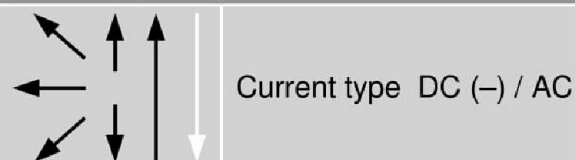
Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A	Impact strength K_v
MPa	MPa	%	J
> 380	> 510	> 22	> 47

Welding instruction

UTP 611 is welded with a short to medium-long arc with slight weaving. It is also very good suited as contact electrode for string beads. The stick electrode should be held at a slight angle to the base material.

Re-drying: 2 – 3 h at 250 – 300°C.

Welding positions



Approvals

TÜV (No. 02180), DB (No. 10.138.08), DNV

Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2,0 x 300	2,5 x 350	3,2 x 350	3,2 x 450	4,0 x 450	5,0 x 450
Amperage [A]	40 – 70	60 – 90	90 – 140	90 – 140	140 – 190	190 – 230

