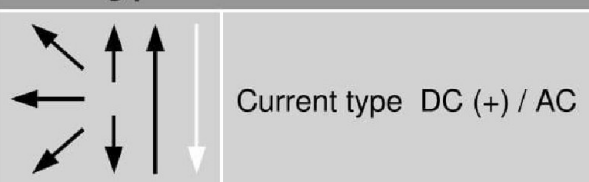


Classifications					
EN ISO 2560-A		AWS A5.1			
E 42 3 B32 H10		E 7018			
Characteristics and field of use					
<p>UTP 614 Kb is a double coated stick electrode with a universally suited application field. It is used in industry, trade, as well as in production and repair welds for diverse base materials.</p> <p>Due to a special coating formula UTP 614 Kb shows a smooth and finely rippled weld seam, a stable arc, easy slag removal, and a very slight increase of the weld, as well as a notch-free seam. The weld metal is little affected by steel impurities. Due to the double coating the stick electrode is excellently suited for root- and out-of-position welding. Recovery 120%, H<sub>2</sub> content &lt; 8 ml/100g.</p>					
Base materials					
Unalloyed construction steels S235JRG2 – S355J2; E295, E335, St35, St 45, St 35.8, St45.8, St50-2 Boiler steels P235GH, P265GH, P295GH Fine-grained steels up to S355N Shipbuilding steels A – E, AH - EH Cast steels C 35, GS-38, GS-45					
Typical analysis in %					
C	Si	Mn	Fe		
0,06	0,7	0,9	balance		
Mechanical properties of the weld metal					
Yield strength R <sub>PO,2</sub>	Tensile strength R <sub>m</sub>	Elongation A	Impact strength K <sub>V</sub>		
MPa	MPa	%	J	-30°C	
> 420	> 510	> 22	> 100	> 47	
Welding instruction					
Ignite the electrode and stay at the ignition point until the electric arc is fully stabilised. Keep a short arc during the welding process. Hold stick electrode vertical to the weldment with slight weaving. Redrying: 2 – 3 h at 250 – 300°C. Only use dry stick electrodes					
Welding positions					
					
Approvals					
TÜV (No. 10571), DB (No. 10.138.03), GL, BV, DNV, ABS, LR					
Recommended welding parameters					
Electrodes Ø x L [mm]	2,5 x 350	3,2 x 350	3,2 x 450	4,0 x 450	5,0 x 450
Amperage [A]	60 – 90	100 – 140	100 – 140	140 – 180	190 – 250

