

## Classifications

EN ISO 14343-A	AWS A5.9	Material-No.
W 29 9	ER 312	1.4337

## Characteristics and field of use

UTP A 651 is suitable for joining and surfacing of steels of difficult weldability, repair of hot and cold working steels, cushioning layers.

The weld metal of UTP A 651 is scale resistant up to 1150° C. Crack and wear resistant, stainless and work hardening.

Hardness of the pure weld metal: approx. 240 HB

## Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0,1	0,4	1,6	30,0	9,0	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 [RT]
650	750	25	27

## Welding instruction

Clean weld area thoroughly. High carboned and solid work pieces depending on shape and size have to be preheated up to 150-250° C. Steady guidance during welding process.

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
1,2 x 1000	DC (-)	I 1
1,6 x 1000	DC (-)	I 1
2,0 x 1000	DC (-)	I 1
2,4 x 1000	DC (-)	I 1
3,2 x 1000	DC (-)	I 1

