

Classifications

EN ISO 14343-A	AWS A5.9	Material-No.
G 19 9 L (Si)	ER 308 L (Si)	1.4316

Characteristics and field of use

UTP A 68 LC is suitable for joining and surfacing in chem. apparatus and vessel construction for working temperatures of $-196\text{ }^{\circ}\text{C}$ up to $350\text{ }^{\circ}\text{C}$.

Base materials

1.4306	X2 CrNi 19-11
1.4311	X2 CrNiN 18-10
1.4312	G-X10 CrNi 18-8
1.4541	X6 CrNiTi 18-10
1.4546	X5 CrNiNb 18-10
1.4550	X6 CrNiNb 18-10

AISI 304; 304L; 302; 321; 347
 ASTM A 1576 Gr. C 9; A 320 Gr. B 8 C oder D

Typical analysis in %

C	Si	Mn	Cr	Ni	Fe
0.02	0.65 – 1.0	1.5	20.0	10.0	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)
400	600	35	100

Approvals

TÜV (No. 00184)

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)		
0.8	DC (+)	M 11	M 12	M 13
1.0	DC (+)	M 11	M 12	M 13
1.2	DC (+)	M 11	M 12	M 13

