

UTP 8 Ko

Standards:
 EN ISO 1071 : ENiCu2
 AWS A5.15 : ~ENiCuB

Graphite-basic coated stick electrode for new iron casting with NiCu-core wire

Application field

UTP 8 Ko is especially suited for production welds on new cast iron parts of grey cast iron. A similarity in colour to the cast material is needed. The weld metal has good stress relieving properties and can be easily machined with cutting tools.

Welding properties

UTP 8 Ko has an easy pulsed arc and spatter free flow which allows for a very good alloying gradient on cast iron. This stick electrode is also suitable for out of position welding.

Mechanical properties of the weld metal

Yield strength R _{p0,2} MPa	Hardness HB
approx. 200	approx. 160

Weld metal analysis in %

C	Ni	Cu	Fe
0,8	balance	30,0	3,0

Welding instruction

Weld area has to be machined to a metallic bright. Defects are machined by milling. UTP 8 AS is used for gouging, the existing oxides have then to be removed mechanically. Weld UTP 8 Ko by using a vertical contact angle and short arc.

Current type DC (✓) / AC

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 300*	3,2 x 350	4,0 x 350*
Amperage	A	60 – 80	80 – 100	80 – 100

* available on request