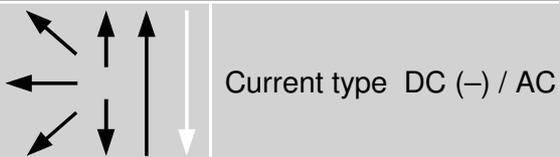


Classifications						
EN ISO 2560-A	AWS A5.1					
E 38 0 RR 12	~ E 6013					
Characteristics and field of use						
<p>UTP 611 is a strongly coated stick electrode for joining and surfacing on all kind of steel constructions. It is used in autobody- and wagon industry, boiler construction and shipbuilding.</p> <p>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.</p>						
Base materials						
<p>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</p>						
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						
<p>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.</p> <p>Re-drying: 2 – 3 h at 250 – 300°C.</p>						
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