

## Classifications

EN ISO 1071	AWS A5.15
E C NiFe-1 3	E NiFe-CI

## Characteristics and field of use

UTP 85 FN is suitable for surfacing and joining of all grades of cast iron, particularly nodular cast iron (GGG 38-60) and for joining these materials with steel and cast steel.

UTP 85 FN has excellent welding properties and a smooth, regular flow, a high deposition rate and a finely rippled bead appearance. Very economic for construction and production welding on nodular cast iron parts. High current carrying capacity thanks to a bimetallic core wire.

## Typical analysis in %

C	Ni	Fe
1,2	54,0	balance

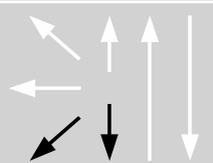
## Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Hardness
MPa	HB
approx. 320	approx. 200

## Welding instruction

Prior to welding, the casting skin has to be removed from the welding area. Hold the stick electrode vertically and with a short arc. Apply string beads – if necessary, with very little weaving. Peen the deposit after slag removal for the purpose of stress relief. Avoid high heat concentration.

## Welding positions



Current type DC (+) / AC

## Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2,5 x 300	3,2 x 350	4,0 x 350	5,0 x 400
Amperage [A]	50 – 70	70 – 100	100 – 130	130 – 160