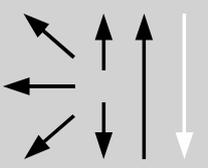


Classifications				
EN ISO 2560-A		AWS A5.1		
E 42 5 B42 H5		~ E 7018-1 H4 R		
Characteristics and field of use				
<p>UTP 613 Kb is a basis-coated stick electrode for construction-, boiler-, tube- and fine-grained steels as well as for steels with up to 0,35% C-content. It is recommended especially for the following base metal.</p> <p>UTP 613 Kb has a good weldability and a stable arc. The weld metal is resistant to ageing, crack resistant and is little affected by steel impurities.</p>				
Base materials				
Construction steels	St 34 - St 60			
Fine-grained-steels	St E 255 - 355			
Boiler steels	H I - H II, 17 Mn 4			
Tube steels	St 35 - St 55, St 35.8, St 45.8			
Cast steels	GS 38 - GS 52			
Typical analysis in %				
C	Si	Mn	Fe	
0,07	0,4	1,1	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	
> 420	> 510	> 25	> 120	
Welding instruction				
<p>Keep a short arc during the welding process. Weld dry stick electrodes only. Re-drying: 2 – 3 h at 250 – 300° C. Preheat weldment if necessary</p>				
Welding positions				
 <p>Current type DC (+)</p>				
Approvals				
TÜV (No. 00794), DB (No. 10.138.02), ABS, BV, DNV				
Recommended welding parameters				
Electrodes $\varnothing \times L$ [mm]	2,5 x 350	3,2 x 350	4,0 x 350	5,0 x 450
Amperage [A]	80 – 100	110 – 150	140 – 200	170 – 210