

AWS A 5.15: E St.

Characteristics

UTP N 817 is non machinable cast iron electrode suited for pickup layers on poorly weldable cast iron as a base for a secondary weld with pure Nickel or Ferro Nickel stick electrode. Wear surfacing can also be performed with one pass weld.
For all cast iron repair welding not requiring machining. Weld metal cracking tendencies are greatly minimized. Nickel free deposits and its colour matches with cast iron. Suitable for all types of sections, thick and thin and for joining of cast iron to steel.

Applications

Sealing oil-soaked cast iron parts, defects, cast iron furnace equipment.

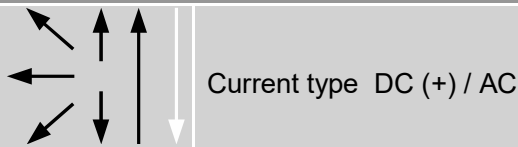
Mechanical properties

- Hardness : 350 BHN

Welding Instruction

Welding area has to be machined to bright finish or prepare the welding area by applying the chamfering stick electrode (UTP N 890 AS). Use AC or DC reverse polarity. Vary arc gap between short and medium to suit. Electrode should be tilted in the direction of travel and arc should be directed on deposited weld metal. Use the beading technique only –do not weave. Clean the weld bead by removing slag with help of brush and chipping hammer

Welding positions



Recommended welding parameters

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Electrodes Ø x L [mm]	2.50 x 350	3.15 x 350	4.0 x 350
Amperage [A]	60 - 90	90 -130	130 -160