UTP 85 FN

Graphite-basic coated FeNi stick electrode

Classifications

AWS A5.15 / SFA-5.15	EN ISO 1071
ENiFe-CI	E C NiFe-13

Characteristics and typical fields of application

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 thank to a bimetallic core wire.

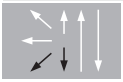
Typical analysis

	C	Ni	Fe
wt.-%	1.2	54	bal.

Mechanical properties of all-weld metal - typical values (min. values)

Yield strength $R_{p0.2}$	Hardness
MPa	HB
320	200

Operating data



Polarity	DC + / AC

Dimension mm	Current A
2.5 x 300	50 – 70
3.2 × 350	70 – 100
4.0 × 350	100 – 130
5.0 × 400	130 – 160

Welding instructions

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.

Approvals

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