

UTP welding consumables for clad plates of stainless or high temperature steels

UTP welding consumables for clad plates of stainless or high temperature steels											
Cladding		Buffer					Subsequent passes				
EN material number	ASTM A 240 type	SMAW	GTAW	GMAW	FCAW	SAW	SMAW	GTAW	GMAW	FCAW	SAW
1.4000	410S	6824 LC	A 6824 LC	A 6824 LC	AF 6824 LC	UP 6824 LC / UP Fx 6824 LC	66	A 66	A 66		
							6824 LC	A 6824 LC	A 6824 LC	AF 6824 LC	UP 6824 LC / UP Fx 6824 LC
1.4301	304	6824 LC	A 6824 LC	A 6824 LC	AF 6824 LC	UP 6824 LC / UP Fx 6824 LC	68 LC	A 68 LC	A 68 LC	AF 68 LC	UP 68 LC / UP Fx 68 LC
1.4306	304L	6824 LC	A 6824 LC	A 6824 LC	AF 6824 LC	UP 6824 LC / UP Fx 6824 LC	68 LC	A 68 LC	A 68 LC	AF 68 LC	UP 68 LC / UP Fx 68 LC
							68 (1)	A 68 (1)	A 68 (1)	AF 68 (1)	UP 68 / UP Fx 68 (1)
1.4541	321	6824 LC	A 6824 LC	A 6824 LC	AF 6824 LC	UP 6824 LC / UP Fx 6824 LC	68 (1)	A 68 (1)	A 68 (1)	AF 68 (1)	UP 68 / UP Fx 68 (1)
1.4550	347	6824 LC	A 6824 LC	A 6824 LC	AF 6824 LC	UP 6824 LC / UP Fx 6824 LC	68 (1)	A 68 (1)	A 68 (1)	AF 68 (1)	UP 68 / UP Fx 68 (1)
1.4401	316	6824 MoLC	A 6824 MoLC	A 6824 MoLC	AF 6824 MoLC	UP 6824 MoLC / UP Fx 6824 MoLC	68 MoLC (2)	A 68 MoLC (2)	A 68 MoLC (2)	AF 68 MoLC (2)	UP 68 MoLC / UP Fx 68 MoLC (2)
1.4404	316L	6824 MoLC	A 6824 MoLC	A 6824 MoLC	AF 6824 MoLC	UP 6824 MoLC / UP Fx 6824 MoLC	68 MoLC (2)	A 68 MoLC (2)	A 68 MoLC (2)	AF 68 MoLC (2)	UP 68 MoLC / UP Fx 68 MoLC (2)
1.4571	316Ti	6824 MoLC	A 6824 MoLC	A 6824 MoLC	AF 6824 MoLC	UP 6824 MoLC / UP Fx 6824 MoLC	68 MoLC (2)	A 68 MoLC (2)	A 68 MoLC (2)	AF 68 MoLC (2)	UP 68 MoLC / UP Fx 68 MoLC (2)
1.4432	316L Mo >2,5	6824 MoLC	A 6824 MoLC	A 6824 MoLC	AF 6824 MoLC	UP 6824 MoLC / UP Fx 6824 MoLC	1817	A 1817	A 1817		UP 1817 / UP Fx 1817
		1817	A 1817	A 1817		UP 1817 / UP Fx 1817	1817	A 1817	A 1817		UP 1817 / UP Fx 1817
1.4435	316 Mo >2,5	6824 MoLC	A 6824 MoLC	A 6824 MoLC	AF 6824 MoLC	UP 6824 MoLC / UP Fx 6824 MoLC	1817	A 1817	A 1817		UP 1817 / UP Fx 1817
		1817	A 1817	A 1817		UP 1817 / UP Fx 1817	1817	A 1817	A 1817		UP 1817 / UP Fx 1817
1.4429	316LN Mo >2,5	6824 MoLC	A 6824 MoLC	A 6824 MoLC	AF 6824 MoLC	UP 6824 MoLC / UP Fx 6824 MoLC	1817	A 1817	A 1817		UP 1817 / UP Fx 1817
		1817	A 1817	A 1817		UP 1817 / UP Fx 1817	1817	A 1817	A 1817		UP 1817 / UP Fx 1817
1.4438	317L	1817	A 1817	A 1817		UP 1817 / UP Fx 1817	1817	A 1817	A 1817		UP 1817 / UP Fx 1817
1.4439	-	1925	A 1925	A 1925		UP 1925 / UP Fx 1925	1925	A 1925	A 1925		UP 1925 / UP Fx 1925
1.4828	305	6824 LC	A 6824 LC	A 6824 LC	AF 6824 LC	UP 6824 LC / UP Fx 6824 LC	6824 LC	A 6824 LC	A 6824 LC	AF 6824 LC	UP 6824 LC / UP Fx 6824 LC
1: To be applied for stress-relief annealing											
1: If stress-relief annealing is applied, please contact us											

Cladding		Filler metal type	
EN material number	ASTM A 240 type	Multi-pass (SMAW*)	
		buffer	subsequent passes
		UTP designation	UTP designation
1.4000	410S	UTP 6824 LC	UTP 66
1.4301	304		UTP 6824 LC
1.4306	304L	UTP 6824 LC	UTP 68 LC UTP 68
1.4541	321		UTP 68 LC
1.4550	347		UTP 68
1.4401	316	UTP 6824 MoLC	UTP 68 MoLC
1.4404	316L		
1.4571	316Ti		UTP 68 Mo
1.4432	316L Mo >2,5		UTP 1817
1.4435	316 Mo >2,5		
1.4429	316LN Mo >2,5		
1.4438	317L	UTP 1817	UTP 1817
1.4439	-	UTP 1925	UTP 1925
1.4828	305	UTP 6824 LC	UTP 6824 LC
* GTAW or GMAW consumables also available with similar composition. The letter "A" must be added between "UTP" and the			

Cladding		Filler metal type					
EN material number	ASTM A 240 type	Multi-pass (SMAW*)					
		buffer			subsequent passes		
		EN	AWS	UTP designation	EN	AWS	UTP designation
1.4000	410S	23 12 L	E 309L	UTP 6824 LC	E 13	E410	UTP 66
1.4301	304				22 12 L	E 309L	UTP 6824 LC
1.4306	304L	23 12 L	E 309L	UTP 6824 LC	19 9 L	E 308L	UTP 68 LC
1.4541	321				19 9 Nb L	E 347L	UTP 68
					19 9 L	E 308L	UTP 68 LC
1.4550	347				19 9 Nb L	E 347L	UTP 68
1.4401	316	23 12 2 L	E 309 MoL	UTP 6824 MoLC	19 12 3 L	E 316L	UTP 68 MoLC
1.4404	316L				19 12 3 Nb	E 318	UTP 68 Mo
1.4571	316Ti						
1.4432	316L Mo >2,5						
1.4435	316 Mo >2,5				18 16 5 L	E 317L	UTP 1817
1.4429	316LN Mo >2,5						
1.4438	317L	18 16 5 L	-	UTP 1817	18 16 5 L	E 317L	UTP 1817
1.4439	-	20 25 6 Cu	-	UTP 1925	20 25 6 Cu L	-	UTP 1925
1.4828	305	23 12 L	E 309L	UTP 6824 LC	23 12 L	E 309L	UTP 6824 LC

* GTAW or GMAW consumables also available with similar composition. The letter "A" must be added between "UTP" and the number.