

Standards

DIN 8573 : E NiFe-1BG12
 AWS A5.15 : ~ ENiFe-CI

UTP 8 FN

**Ferro-niquel electrode for welding cast iron.
 Deposits and maquinables transition áreas.**

Aplication field

UTP 8 FN is suitable for surfacing of all commercial cast iron grades, as well as to join the iron casting to steel. Particularly suitable for welding of nodular cast iron. Can also be applied in welding combined with **UTP 8**.

Welding properties

It produces a smooth and stable arc. The transfer of the metal in the arc by fine droplets, results in high mechanical values and a deposit free of cracks.

Mechanical properties of the weld metal

Tensile strength MPa N/mm ²	Brinell Hardness
> 320	>190

Weld metal analysis in %

C	Mn	Si	S	Ni	Cu	Al	Fe
< 2,0	< 2,5	< 4,0	< 0,03	45 - 60	< 2,5	< 1,0	Balance

Welding instruction

Depending on the wall of the work piece, the preparation is made of U-shaped or double U. The crust material must be removed in both areas to be welded. Hold electrode in vertical position with short arc. Use the lowest rating possible. The width of the cord should not be more than 2 times the diameter of the electrode rod. At the end of the cord, keep the bow to fill the final crater. The length of the cord should not exceed more than 10 times the diameter of the electrode with the purpose of avoiding an envelope the workpiece heating. Remove slag immediately after each cord and hammer the tank to reduce internal tensions that are generated during the welding process. always restart the arc on welding, never on the base metal deposit.

Current type:

(= +)

Welding positions



1 G



2 F



2 G



3 G



4 G

Current adjustment

Electrodes	Ø x L (mm)	2.4mm (3/32") x 250	3.2mm (1/8") x 300	4.0mm (5/32") x 400
Amperage	(A)	60 - 80	80 - 100	110 - 140