

## UTP 614 Kb

### Standard :

EN ISO 2560-A : E 42 3 B32 H10  
AWS A5.1 : E 7018

**Basic-coated stick electrode for constructions with high stressed joints, AC-weldable**

### Application field

**UTP 614 Kb** is a double coated stick electrode with a universally suited application field. It is used in industry, trade, as well as in production and repair welds for diverse bas materials.

### Base materials:

Unalloyed construction steels S235JRG2 – S355J2; E295, E335, St35, St 45, St 35.8, St45.8, St50-2  
Boiler steels P235GH, P265GH, P295GH  
Fine-grained steels bis S355N  
Shipbuilding steels A – E, AH - EH  
Cast steels C 35, GS-38, GS-45

### Welding properties

Due to a special coating formula **UTP 614 Kb** shows a smooth and finely rippled weld seam, a stable arc, easy slag removal, and a very slight increase of the weld, as well as a notch-free seam. The weld metal is little affected by steel impurities. Due to the double coating the stick electrode is excellently suited for root- and out-of-position welding. Recovery 120%, H2 content < 8 ml/100g.

### Mechanical properties of the weld metal

Yield strength $R_e$ MPa	Tensile strength $R_m$ MPa	Elongation A %	Impact strength $K_v$ Joule
> 400	> 510	> 22	80

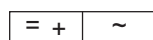
### Weld metal analysis in %

C	Si	Mn	Fe
0,06	0,7	0,9	balance

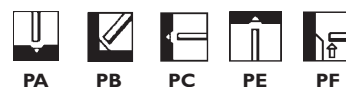
### Welding instruction

Keep a short arc during the welding process. Hold stick electrode vertical to the weldment. Little heat input and string bead technique should be applied. The interpass temperature should not exceed 150°C. Re-drying: 2 - 3 h at 250 - 300°C.

### Current type



### Welding positions



### Availability / Current adjustments

Stick electrodes	Ø mm x L	2,5 x 300	3,2 x 350	4,0 x 350	5,0 x 450
Amperage	A	60 - 90	100 - 150	140 - 190	190 - 250

### Approvals

TÜV (No. 10571), DB (No. 10.138.03), GL, BV, DNV, ABS, LR