



Filler Metals for Repair of Cracked Material

		Unalloyed and low alloyed steels	High alloyed steels	Stainless steels	Nickel alloys	Cast iron	Manganese steels	Copper alloys	Classification				Material-No.	
									DIN	EN / EN ISO	AWS	ASME		
Covered Electrodes	UTP 611	•								E 38 0 RR 12	~ E 6013			
	UTP 614 Kb	•								E 42 3 B32 H10	E 7018			
	UTP 63			•						E 18 8 Mn R 3 2				1.4370
	UTP 68 LC			•						E 19 9 L R 3 2	E 308 L-17			1.4316
	UTP 68 MoLC			•						E 19 12 3 L R 3 2	E 316 L-17			1.4430
	UTP 6824 LC			•						E 23 12 L R 3 2	E 309 L-17			~1.4332
	UTP 068 HH				•					E Ni 6082 (NiCr20Mn3Nb)	E NiCrFe-3 (mod.)			2.4648
	UTP 6222 Mo				•					E Ni 6625 (NiCr22Mo9Nb)	E NiCrMo-3			2.4621
	UTP 83 FN						•			E C NiFe-11	E NiFe-CI			
	UTP 86 FN						•			E C NiFe-13	E NiFe-CI			
	UTP 387							•	EL-CuNi30Mn		E CuNi			2.0837
TIG Rods	UTP A 63			•						W 18 8 Mn	ER 307 (mod.)			1.4370
	UTP A 68 LC			•						W 19 9 L (Si)	ER 308 L (Si)			1.4316
	UTP A 68 MoLC			•						W 19 12 3 L (Si)	ER 316 L (Si)			1.4430
	UTP A 6824 LC			•						W 23 12 L (Si)	ER 309 L (Si)			1.4332
	UTP A 068 HH				•					S Ni 6082 (NiCr20Mn3Nb)	ER NiCr-3			2.4806
	UTP A 6222 Mo				•					S Ni 6625 (NiCr22Mo9Nb)	ER NiCrMo-3			2.4831
	UTP A 8051 Ti					•				S C NiFe-2				
	UTP A 387							•		S Cu 7158 (CuNi30Mn1FeTi)	ER CuNi			2.0837
Solid Wires	UTP A 119	•								G 46 2 C1 4Si1 G 46 4 M21 4Si1	ER70S-6			
	UTP A 63			•						G 18 8 Mn	ER 307 (mod.)			1.4370
	UTP A 68 LC			•						G 19 9 L (Si)	ER 308 L (Si)			1.4316
	UTP A 68 MoLC			•						G 19 12 3 L (Si)	ER 316 L (Si)			1.4430
	UTP A 6824 LC			•						G 23 12 L (Si)	ER 309 L (Si)			1.4332
	UTP A 068 HH				•					S Ni 6082 (NiCr20Mn3Nb)	ER NiCr-3			2.4806
	UTP A 6222 Mo				•					S Ni 6625 (NiCr22Mo9Nb)	ER NiCrMo-3			2.4831
	UTP A 8051 Ti					•				S C NiFe-2				
	UTP A 387							•		S Cu 7158 (CuNi30Mn1FeTi)	ER CuNi			2.0837
Gas Shielded Cored Wires	UTP AF 152	•								T 46 4 P M 1 H10 T 42 2 P C 1 H5	E71T1-M21A4-CS1-H8 E71T1-C1A2-CS1-H4			
	SK 402-G			•						MF 8-GF-150-KP				
	UTP AF 68 LC			•						T 19 9 L RM3 T 19 9 L RC3	E 308 LT-0-1 E 308 LT-0-4			1.4316
	UTP AF 6824 LC			•						T 23 12 L RM3 T 23 12 L RC3		E 309 LT 0-1 E 309 LT 0-4		1.4332
	SK FNM-G				•									
Open Arc Cored Wires	SK BU-C1	•								MF 1-GF-250-P				
	SK 402-O			•						MF 8-GF-150/400-KPZ				
	SK 308L-O			•						MF 9-GF-150-C		E 308L-T3		
	SK 316L-O			•						MF 9-GF-150-C		E 316L-T3		
	SK 309L-O			•						MF 9-GF-150				
	SK FN-O					•				(ca.) MF NiFe-1-S				