LEADER IN INDUSTRIAL TOOLS & EQUIPMENT

Technical sheet



BOHLER Graphite-basic coated FeNi stick electrode UTP 86 FN-2,50X0300

Marque: BÖHLER- GERMANY

Ref Product: wire:14901

Ref Mcmining:

Description	
14901	
BOHLER Graphite-basic coated FeNi stick electrode UTP 86 FN-2,50X0300 UTP 86 FN is suitable for joining and surfacing of lamellar grey cast iron EN GJL 100 - EN GJL 400, nodular cast iron (spheroidal cast iron) EN GJS 400 - EN GJS 700 and malleable cast iron grades EN GJMB 350 - EN GJMB 650 as well as for joining these materials with each other or with steel and cast steel. Universally applicable for repair, construction and production welding. UTP 86 FN has excellent buttering characteristics on cast iron. The stick electrode has a stable arc and produces a flat seam structure without undercutting. Particularly for fillet welds an optimal seam structure is achieved (e.g. welding GJS-flanges or sockets to GJS-tubes). Due to the bimetallic core wire, the current carrying capacity and the deposition rate are excellent. The bead appearance is smooth. The weld deposit is highly crack resistant and easily machinable with cutting tools.	
CLASSIFICATION	
AWS A5.15 / SFA-5.15:	ENiFe-Cl E
EN ISO 1071:	C NiFe-13
Product specification:	
Dimension:	2,50x300mm
Current A:	60-90
CERTIFICATION	
DB (Nr. 62.138.05)	