

Tailor-Made Protectivity™

CLADDING FILLER METALS AGAINST CORROSION



CLADDING PRODUCT LINE

High-quality industrial-use cladding filler metals for anti-corrosion applications

Tailor-Made Protectivity™

Industry experience and application know-how combined with innovative and custom (tailor-made) cladding products guarantee that our customers obtain the ideal combination of productivity and protection, within the shortest operating times and up to the maximum performance capacity of their products.

Cladding

Cladding is defined as the process of protecting one metal by bonding a second metal to its surface. Providing a corrosion or oxidation resistant surface on less corrosion resistant material, e.g. cladding of stainless steel or nickel-based layer on a carbon steel base.

Industry Fokus

Oil & Gas Upstream, Oil & Gas Downstream, Chemical, Power Generation, Steelworks, Mining, Pumps, Valves & Fittings, Pulp & Paper

CONTENTS

Introduction	2
Covered Electrodes	3
TIG Rods	4
Solid Wires	5
Cold & Hot Wires	5
Gas Shielded Cored Wires	6 - 7
Open Arc Cored Wires	7
SAW Solid Wires	8
SAW Cored Wires	8
Strips	9
Solutions for Strip Cladding	10

Covered Electrodes for Cladding Applications (Anti-corrosion)

Name	Classification	Mechanical properties of the weld metal		Characteristics and field of use
UTP 68 rutile coated stick electrode	EN ISO 3581-A E 19 9 Nb R 3 2	Yield strength R_{p0,2} > 380 MPa	Tensile strength R_m > 590 MPa	UTP 68 is suitable for joining and surfacing (cladding) of stabilized and non stabilized CrNi steels and CrNi cast steels.
	AWS A5.4 E 347-17	Elongation A > 30 %	Impact strength K_v > 47 J (RT)	
UTP 68 LC low carbon stick electrode	EN ISO 3581-A E 19 9 L R 3 2	Yield strength R_{p0,2} > 350 MPa	Tensile strength R_m > 520 MPa	UTP 68 LC, with a low carbon content, is used for repair and building up of identical low carbon, austenitic CrNi steels and CrNi cast steels.
	AWS A5.4 E 308 L-17	Elongation A > 35 %	Impact strength K_v > 47 J (RT)	
UTP 68 Mo stabilized stick electrode	EN ISO 3581-A E 19 12 3 Nb R 3 2	Yield strength R_{p0,2} 380 MPa	Tensile strength R_m 560 MPa	UTP 68 Mo is used for repair and surfacing of stabilized and non-stabilized CrNiMo steels and CrNiMo cast steels.
	AWS A5.4 E 318-16	Elongation A 30 %	Impact strength K_v 55 J (RT)	
UTP 68 MoLC low carbon stick electrode	EN ISO 3581-A E 19 12 3 L R 3 2	Yield strength R_{p0,2} 380 MPa	Tensile strength R_m 560 MPa	UTP 68 MoLC, with a low carbon content, is used for repair and surfacing of identical, low carbon, austenitic CrNiMo steels and CrNiMo cast steels.
	AWS A5.4 E 316 L-17	Elongation A 30 %	Impact strength K_v 60 J (RT)	
UTP 759 Kb basic coated NiCrMo stick electrode	EN ISO 14172 E Ni 6059 (NiCr23Mo16)	Yield strength R_{p0,2} > 450 MPa	Tensile strength R_m > 720 MPa	UTP 759 Kb is employed primarily for welding components in environmental plants and plants for chemical processes with highly corrosive media. Cladding on low-alloyed steels.
	AWS A5.11 E NiCrMo-13	Elongation A > 30 %	Impact strength K_v > 60 J (RT)	
UTP 776 Kb basic covered electrode	EN ISO 14172 E Ni 6276 (NiCr-15Mo15Fe6W4)	Yield strength R_{p0,2} > 450 MPa	Tensile strength R_m > 720 MPa	UTP 776 Kb is employed primarily for joint welding of matching base materials, as Material-No. 2.4819 (NiMo16Cr15W) and surfacing (cladding) on low-alloyed steels.
	AWS A5.11 E NiCrMo-4	Elongation A > 30 %	Impact strength K_v > 70 J (RT)	
UTP 4225 basic covered electrode	EN ISO 14172 E Ni 8165 (NiCr25Fe30Mo)	Yield strength R_{p0,2} > 350 MPa	Tensile strength R_m > 550 MPa	UTP 4225 is suitable for joining and surfacing (cladding) of alloys of similar nature, such as e. g. NiCr21Mo, furthermore for welding of CrNiMoCu-alloyed austenitic steels used for high quality tank and apparatus construction in the chemical industry, corrosion resistance in media of sulphuric- and phosphoric acid.
		Elongation A > 30 %	Impact strength K_v > 80 J (RT)	
UTP 6222 Mo basic coated NiCrMo-stick electrode	EN ISO 14172 E Ni 6625 (NiCr22Mo9Nb)	Yield strength R_{p0,2} > 450 MPa	Tensile strength R_m > 760 MPa	UTP 6222 Mo is particularly suited for joining and surfacing (cladding) on nickel alloys, austenitic steels, low temperature nickel steels, austenitic-ferritic-joints and claddings of the same or similar nature, like 2.4856 (NiCr22Mo9Nb), 1.4876 (X30 NiCrAlTi 32 20), 1.4529 (X2 NiCrMoCu 25 20 5).
	AWS A5.11 E NiCrMo-3	Elongation A > 30 %	Impact strength K_v > 75 J (RT)/ > 45 J (-196 °C)	



TIG Rods for Cladding Applications (Anti-corrosion)

Name	Classification	Mechanical properties of the weld metal		Characteristics and field of use
UTP A 68	EN ISO 14343-A W 19 9 Nb Si	Yield strength R_{p0,2} > 420 MPa	Tensile strength R_m > 600 MPa	UTP A 68 is suitable for surfacing (cladding) in chemical apparatus and vessel construction for working temperatures of -196 °C up to 400 °C.
	AWS A 5.9 ER 347 (Si)	Elongation A > 30 %	Impact strength K_v > 100 J (RT)	
UTP A 68 LC	EN ISO 14343-A W 19 9 L (Si)	Yield strength R_{p0,2} 400 MPa	Tensile strength R_m 600 MPa	UTP A 68 LC is suitable for surfacing (cladding) in chemical apparatus and vessel construction for working temperatures of -196 °C up to 350 °C.
	AWS A5.9 ER 308 L (Si)	Elongation A 35 %	Impact strength K_v 100 J (RT)	
UTP A 68 Mo	EN ISO 14343-A W 19 12 3 Nb (Si)	Yield strength R_{p0,2} 460 MPa	Tensile strength R_m 680 MPa	UTP A 68 Mo is applicable for surfacing (cladding) of stabilized, corrosion resistant CrNiMo steels of similar nature in the construction of chemical apparatus and vessels up to working temperatures of -120 °C up to 400 °C.
	AWS A5.9 ER 318 (Si)	Elongation A 35 %	Impact strength K_v 100 J (RT)	
UTP A 68 MoLC	EN ISO 14343-A W 19 12 3 L (Si)	Yield strength R_{p0,2} 420 MPa	Tensile strength R_m 600 MPa	UTP A 68 MoLC is used for surfacing (cladding) of low-carbon, corrosion resistant CrNiMo steels exposed to high corrosion for working temperatures up to 350 °C.
	AWS A5.9 ER 316 L (Si)	Elongation A 35 %	Impact strength K_v 100 J (RT)	
UTP A 759	EN ISO 18274 S Ni 6059 (NiCr23Mo16)	Yield strength R_{p0,2} > 450 MPa	Tensile strength R_m > 720 MPa	UTP A 759 is suitable for welding components in plants for chemical processes with highly corrosive media, for joining materials of the same or similar natures and materials with low alloyed steels as well as for surfacing (cladding) on low alloyed steels.
	AWS A5.14 ER NiCrMo-13	Elongation A > 35 %	Impact strength K_v > 100 J (RT)	
UTP A 776	EN ISO 18274 S Ni 6276 (NiCr- 15Mo16Fe6W4)	Yield strength R_{p0,2} > 450 MPa	Tensile strength R_m > 750 MPa	UTP A 776 is suitable for joint welding of matching base materials, as 2.4819 NiMo16Cr15W UNS N10276 and surfacing (cladding) on low-alloyed steels.
	AWS A5.14 ER NiCrMo-4	Elongation A > 30 %	Impact strength K_v > 90 J (RT)	
UTP A 4221	EN ISO 18274 S Ni 8065 (NiFe30Cr21Mo3)	Yield strength R_{p0,2} 360 MPa	Tensile strength R_m > 550 MPa	UTP A 4221 is suitable for joining and surfacing (cladding) of alloys of similar nature, furthermore for welding of CrNiMoCu-alloyed austenitic steels used for high quality tank and apparatus construction in the chemical industry, corrosion resistance in media of sulphuric and phosphoric acid.
	AWS A5.14 ER NiFeCr-1 (UNS N08065)	Elongation A > 30 %	Impact strength K_v > 100 J (RT)	
UTP A 6222 Mo	EN ISO 18274 S Ni 6625 (NiCr22Mo9Nb)	Yield strength R_{p0,2} > 460 MPa	Tensile strength R_m > 740 MPa	UTP A 6222 Mo has a high nickel content and is suitable for welding high-strength and high-corrosion resistant nickel-base alloys. It can be used for joining ferritic steel to austenitic steel as well as for surfacing (cladding) on steel. It is also possible to weld 9 % nickel steels using this wire due to its high yield strength.
	AWS A5.14 ER NiCrMo-3	Elongation A > 30 %	Impact strength K_v > 100 J (RT)/ > 85 J (-196 °C)	



Solid Wires for Cladding Applications (Anti-corrosion)

Name	Classification	Mechanical properties of the weld metal		Characteristics and field of use
UTP A 68	EN ISO 14343-A G 19 9 Nb Si	Yield strength R_{p0,2} > 420 MPa	Tensile strength R_m > 600 MPa	UTP A 68 is suitable for surfacing (cladding) in chemical apparatus and vessel construction for working temperatures of -196 °C up to 400 °C.
	AWS A5.9 ER 347 (Si)	Elongation A > 30 %	Impact strength K_v > 100 J (RT)	
UTP A 68 LC	EN ISO 14343-A G 19 9 L (Si)	Yield strength R_{p0,2} 400 MPa	Tensile strength R_m 600 MPa	UTP A 68 LC is suitable for surfacing in chemical apparatus and vessel construction for working temperatures of -196 °C up to 350 °C.
	AWS A5.9 ER 308 L (Si)	Elongation A 35 %	Impact strength K_v 100 J (RT)	
UTP A 68 Mo	EN ISO 14343-A G 19 12 3 Nb (Si)	Yield strength R_{p0,2} 460 MPa	Tensile strength R_m 680 MPa	UTP A 68 Mo is applicable for surfacing (cladding) of stabilized, corrosion resistant CrNiMo steels of similar nature in the construction of chemical apparatus and vessels for working temperatures of -120 °C up to 400 °C.
	AWS A5.9 ER 318 (Si)	Elongation A 35 %	Impact strength K_v 100 J (RT)	
UTP A 68 MoLC	EN ISO 14343-A G 19 12 3 L (Si)	Yield strength R_{p0,2} 420 MPa	Tensile strength R_m 600 MPa	UTP A 68 MoLC is used for surfacing (cladding) of low-carbon, corrosion resistant CrNiMo steels exposed to high corrosion for working temperatures up to 350 °C.
	AWS A5.9 ER 316 L (Si)	Elongation A 35 %	Impact strength K_v 100 J (RT)	
UTP A 786	EN ISO 18274 S Ni 6686 (NiCr21Mo16W4)	Yield strength R_{p0,2} > 450 MPa	Tensile strength R_m > 760 MPa	UTP A 786 is particularly designed for claddings of desulphurization and waste incineration components, such as pipes and finned tubes made of heat resistant steels.
	AWS A5.14 ER NiCrMo-14	Elongation A > 30 %	Impact strength K_v > 50 J (RT)	
UTP A 4221	EN ISO 18274 S Ni 8065 (NiFe30Cr21Mo3)	Yield strength R_{p0,2} 360 MPa	Tensile strength R_m > 550 MPa	UTP A 4221 is suitable for joining and surfacing (cladding) of alloys of similar nature, furthermore for welding of CrNiMoCu-alloyed austenitic steels used for high quality tank and apparatus construction in the chemical industry, corrosion resistance in media of sulphuric and phosphoric acid.
	AWS A5.14 ER NiFeCr-1 (UNS N08065)	Elongation A > 30 %	Impact strength K_v > 100 J (RT)	
UTP A 6222 Mo	EN ISO 18274 S Ni 6625 (NiCr22Mo9Nb)	Yield strength R_{p0,2} 460 MPa	Tensile strength R_m > 740 MPa	UTP A 6222 Mo has a high nickel content and is suitable for welding high-strength and high-corrosion resistant nickel-base alloys. It can be used for joining ferritic steel to austenitic steel as well as for surfacing (cladding) on steel. It is also possible to weld 9 % nickel steels using this wire due to its high yield strength.
	AWS A5.14 ER NiCrMo-3	Elongation A > 30 %	Impact strength K_v > 100 J (RT)/ > 85 J (-196 °C)	

Cold & Hot Wire TIG Applications

Name	Classification	Characteristics and field of use
UTP A 6222 Mo-3	EN ISO 18274 S Ni 6625 (NiCr22Mo9Nb)	UTP A 6222 Mo-3 has been developed for applications in the oil & gas industry, and is mainly used for cladding and joining of unalloyed and high strength low alloyed steel (HSLA) components. Typical applications are internal cladding of tubes & pipes, risers, and subsea components such as manifolds, BOPs, Christmas trees, well heads, flanges, valve bodies, blocks etc. to improve corrosion resistance to surfaces exposed to hydrocarbon and hydrogen sulphide.
	AWS A5.14 ER NiCrMo-3	

Gas Shielded Wires for Cladding Applications (Anti-corrosion)

Name	Classification	Hardness		Composition (All weld metal)														Characteristics and field of use	
		HB	HRC	C	Mn	Si	Cr	Ni	Mo	Co	Nb	Ti	W	Al	V	B	Fe		
SK 430-G	DIN 8555 MF 5-GF-200-C	190		0,06	0,80	0,60	17,80					0,20						Bal.	Alloy depositing a ferritic steel containing 17 % Chromium designed to resist corrosion at high temperatures, particularly in presence of sulphurous gas.
SK 519-G	DIN 8555 MF 8-GF-C DIN 8556 MSG X2-CrNi- MoCu 20-25			0,02	2,80	0,50	20,50	24,20	5,00									Bal.	For welding and cladding stainless steels of similar composition where corrosion resistance to hot sulphuric and cold hydrochloric acid is required.
SK 741-G	DIN 8555 MF 5-GF-40-C		41	0,06	0,50	0,60	13,00	5,50	0,80									Bal.	Alloy depositing a ferritic-martensitic steel containing 13 % Chromium, 5 % Nickel and 1 % Molybdenum. Designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking. Field of use: surfacing (cladding) of continuous casting rollers of very small diameters (<150mm).
SK 768-G	DIN 8555 MF 5-GF-350-C		34	0,02	0,30	0,30	14,50	6,30	2,50									Bal.	Alloy depositing a ferritic-martensitic steel containing 13 % Chromium, 5 % Nickel and 2 % Molybdenum. Designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking. Field of use: surfacing (cladding) of continuous casting rollers of very small diameters (< 150mm).
SK TOOL ALLOY Co-G	DIN 8555 MF 23-GF-200-CKZ	220		0,03	1,30	0,70	16,00	Bal.	16,00	2,50			4,00					3,00	NiCrMo alloy with addition of Cobalt. Designed for hard-surfacing of parts subject to oxidation, corrosion and mechanical stresses at high temperature (1,100 °C). For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode. Field of use: punches for extrusion of steel pipes, hot working tools.
SK U 521-G	DIN 8555 MF 23-GF-200-TZ	200		0,01		0,30	18,50	Bal.	4,50	12,50		3,50		1,00				1,80	Nickel-base super-alloy with addition of Cobalt providing the most powerful strengthening effect at high temperature due to the precipitation of Ni ₃ (AlTi) phase. Enhanced weldability. Field of use: rebuilding of forging hammers.
SK STELKAY 1-G	DIN 8555 MF 20-GF-55-CTZ		54	2,30	0,80	1,60	26,50			Bal.			11,50					3,00	Cobalt base alloy providing excellent resistance to metal-to-metal wear, oxidation and high stress abrasion wear, in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode. Field of use: mill guides, palm nut oil extruder, plastic extrusion screws, mixer blades, scrapers, rubber mixer.

Name	Classification	Hardness		Composition (All weld metal)														Characteristics and field of use	
		HB	HRC	C	Mn	Si	Cr	Ni	Mo	Co	Nb	Ti	W	Al	V	B	Fe		
SK STELKAY 6-G	DIN 8555 MF 20-GF-40-CTZ		40	0,95	0,80	1,40	30,00				Bal.							3,00	Cobalt base alloy providing excellent resistance to metal-to-metal wear, oxidation, thermal cycling and impact in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode. Field of use: valves, valve seats in motor vehicles, hot shear blades, extruder screws, clack valves and seats, dies, punches.
SK STELKAY 6 A-G	DIN 8555 MF 20-GF-45-CTZ		43	1,35	0,80	1,50	27,00				Bal.							3,00	Cobalt base alloy providing excellent resistance to metal-to-metal wear, oxidation, thermal cycling and impact in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode. Field of use: valves, valve seats in motor vehicles, hot shear blades, extruder screws, clack valves and seats, dies, punches.

Open Arc Cored Wires for Cladding Applications (Anti-corrosion)

Name	Classification	Hardness		Composition (All weld metal)														Characteristics and field of use		
		HB	HRC	C	Mn	Si	Cr	Ni	Mo	Nb	Ti	W	V	N	Fe					
SK 714 N-O	DIN 8555 MF 5-GF-45		44	0,03	1,00	0,60	13,00	4,20	0,50									0,10	Bal.	Alloy depositing a ferritic-martensitic steel with addition of nitrogen, designed to resist metal-to-metal wear, corrosion and thermal fatigue. Field of use: cladding of continuous casting rollers.
SK 741-O	DIN 8555 MF 5-GF-45-C	HB	HRC	C	Mn	Si	Cr	Ni	Mo	Nb	Ti	W	V	B	Fe				Bal.	Alloy depositing a ferritic-martensitic steel containing 13 % Chromium, 5 % Nickel and 1 % Molybdenum designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking. Field of use: cladding of continuous casting rollers.
			43	0,02	0,60	0,60	12,60	5,20	0,80											



SAW Solid Wires for Cladding Applications (Anti-corrosion)

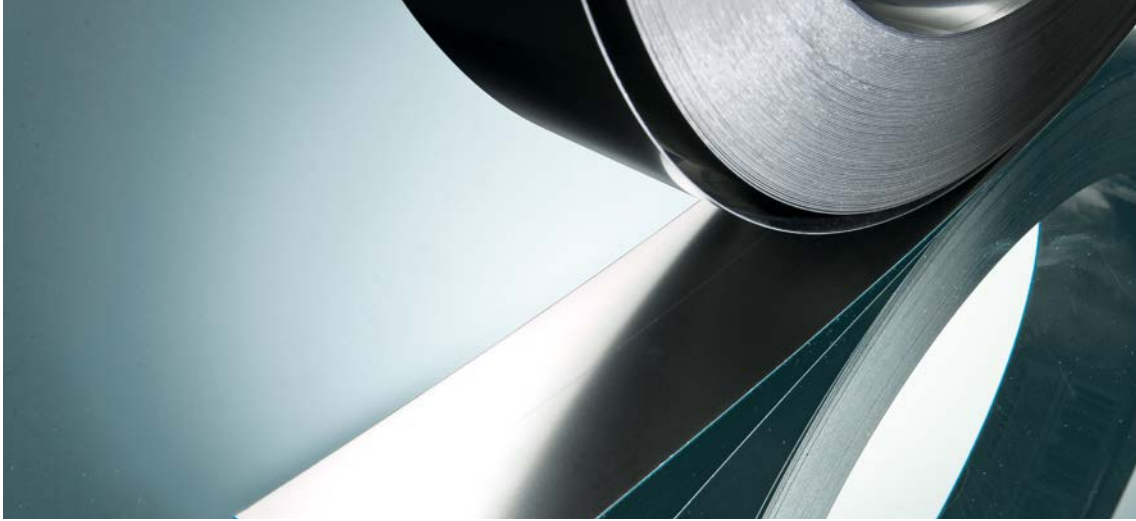
Name	Classification	Composition (All weld metal)		Characteristics and field of use
UTP UP 776 + RECORD Pulver (1)	EN ISO 18274 S Ni 6276 (NiCr- 15Mo16Fe6W4)	Yield strength R_{p0,2} > 450 MPa	Tensile strength R_m > 690 MPa	UTP UP 776 is suitable for joining and surfacing (clad- ding) on matching and similar alloys such as 2.4819 NiMo16Cr15W UNS N10276 and surface claddings on low-alloyed steels.
	AWS A5.14 ER NiCrMo-4	Elongation A > 35 %	Impact strength K_v > 70 J (RT)	
UTP UP 6222 Mo + RECORD Pulver (1)	EN ISO 18274 S Ni 6625 (NiCr22Mo9Nb)	Yield strength R_{p0,2} 460 MPa	Tensile strength R_m 725 MPa	UTP UP 6222 Mo is applied for joint welding of base materials with the same or with a similar composition, e.g. Alloy 625 (UNS N06625) or NiCr22Mo9Nb, Mate- rial-No. 2.4856 or mixed combinations with stain- less steels and carbon steels. UTP UP 6222 Mo is also applied on alloyed or unalloyed steels for cladding of corrosion resistant plants.
	AWS A5.14 ER NiCrMo-3	Elongation A 40 %	Impact strength K_v > 80 J (RT)/ 65 J (-196 °C)	

(1) Please contact your sales representative for the matching wire / flux combination

SAW Cored Wires for Cladding Applications (Anti-corrosion)

Name	Classification	Hardness		Composition (All weld metal)												Characteristics and field of use	
		HB	HRC	C	Mn	Si	Cr	Ni	Mo	Nb	Ti	W	V	N	Fe		
SK 410 NiMo-SA + RECORD SA	DIN 8555 UP 5-GF-40-C		39	0,05	1,00	0,30	12,50	5,00	0,90							Bal.	Alloy depositing a ferritic-martensitic steel containing 13 % Chromium, 5 % Nickel and 1 % Molybdenum. Designed to resist met- al-to-metal wear, corrosion and thermal fatigue fire cracking. Field of use: continu- ous casting rollers.
SK 415-SA + RECORD SA RECORD SK	DIN 8555 UP 5-GF-45-C		42	0,08	0,90	0,40	13,50	2,10	1,10	0,20				0,30		Bal.	Alloy depositing a ferritic-martensitic steel designed to resist metal-to-metal wear, cor- rosion and thermal fatigue. Field of use: continuous casting rollers.
SK 420-SA + RECORD SA	DIN 8555 UP 6-GF-55-C		53	0,27	1,30	0,30	13,50									Bal.	Alloy depositing a martensitic steel contain- ing 13 % Chromium giving a good resist- ance to metal-to-metal wear and corrosion. Field of use: dredging pump casings, contin- uous casting rollers.
SK 430C-SA + RECORD SA RECORD SK	DIN 8555 UP 5-GF-200-C	175		0,04	0,90	0,50	19,50									Bal.	Alloy depositing a ferritic steel containing 17 % Chromium. Designed to resist corro- sion at high temperatures, particularly in presence of sulphurous gas. Field of use: continuous casting rollers situated at the top of the line.
SK 461C-SA + RECORD SA RECORD SK	DIN 8555 UP 6-GF-50-C		54	0,26	0,90	0,50	12,20	0,40	1,40	1,80		0,90	1,00			Bal.	Alloy depositing a ferritic-martensitic steel designed to resist metal-to-metal wear, cor- rosion and thermal fatigue fire cracking. Field of use: continuous casting rollers.
SK 742 N-SK + RECORD SK	DIN 8555 UP 5-GF-45-C	HB	HRC	C	Mn	Si	Cr	Ni	Mo	Nb	Ti	W	V	N	Fe		Alloy depositing a ferritic-martensitic steel with addition of Nitrogen. Designed to enhance the resistance to thermal fatigue and intragranular corrosion by reducing the formation of carbides at grain boundaries. Field of use: continuous casting rollers.
			44	0,04	1,20	0,40	13,50	3,30	1,30	0,10			0,15	0,06	Bal.		

Please contact your sales representative for the matching wire / flux combination



Our SOUDOTAPE Strips and Record fluxes are summarized in the special brochure “Strips and Fluxes for Electroslag and Submerged Arc Welding”. UTP Maintenance offers a full and unique strip & flux product portfolio for electroslag and submerged strip cladding of all types of alloys:

- » unalloyed and low alloyed
- » martensitic alloys (420, 430, 410NiMo ...)
- » standard stainless steels (308L, 316, 347 ...)
- » special stainless steels (317L, 318, 904L, duplex, superduplex ...)
- » Nickel alloys (600, 625, 825, C22, C276, alloy 59, alloy 400 ...)
- » Cobalt alloys and CuNi alloys

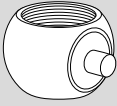
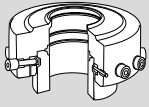
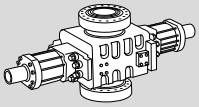
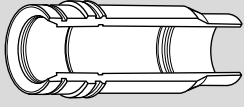
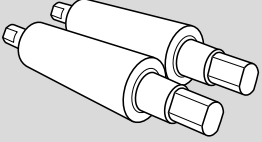
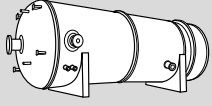

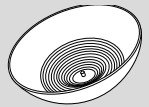
UTP Maintenance also offers specially designed cladding nozzles to perform strip cladding from small pipes to very large vessels (SK 30ES2-300, SK 60 ES3-207, SK 125 ES1-300 ...).

Just contact us for additional information, further technical data or any questions regarding strips and fluxes.

Alloy	Type of strip	Type of flux		C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Cu	FN	Hardness
316L	SOUDOTAPE 21.13.3L	RECORD EST 122	ESW/ single layer	0,03	1,30	0,40	18,20	12,60	2,60		R		6,00	
347	SOUDOTAPE 21.11.LNb	RECORD EST 122	ESW/ single layer	0,03	1,40	0,40	19,00	10,10		0,50	R		7,00	
410NiMo	SOUDOTAPE 430	RECORD RT 152	SAW/ 2 layer	0,04	0,50	0,90	13,90	3,80	0,90		R			390 HB
904L	SOUDOTAPE 20.25.5LCu	RECORD EST 385-1	ESW/ single layer	0,02	2,50	0,10	19,40	25,00	4,40		R	1,30		
825	SOUDOTAPE 825	RECORD EST 138	ESW/ single layer	0,02	0,60	0,60	22,30	R	2,80		34,00	1,50		
625	SOUDOTAPE 625	RECORD EST 625-1	ESW/ single layer	0,03	0,20	0,30	21,50	R	9,00	3,50	7,90			

Please contact your sales representative for further information.

Solutions for Cladding

	UTP Maintenance Product	Process
Ball Valves 	UTP A 6222 Mo UTP A 6222 Mo-3 SOUDOTAPE 625 + Record Fluxes	GTAW & GMAW Cold and Hot Wire GTAW/TIG ESW/SAW Strip Cladding
Wellhead Connectors 	UTP A 6222 Mo-3	Cold and Hot Wire GTAW/TIG
Blow Out Preventer "BOP" 	SOUDOTAPE A + RECORD NiMoT	SAW Strip Cladding
Wellhead Housing 	UTP A 6222 Mo-3	Cold and Hot Wire GTAW/TIG
Continuous Casting Rollers 	SK 741-G SK 714 N-O SK 742 N-SK + RECORD SK SOUDOTAPE 430 + RECORD RT152	FCAW-G FCAW-O SAW SAW Strip Cladding
Vessels 	SOUDOTAPE Strips and Record Fluxes alloy 316, 347, 625, 825, NiCu ...	ESW/SAW Strip Cladding
Pipes 	UTP A 6222 Mo UTP A 6222 Mo-3 SOUDOTAPE 625/825 + RECORD Fluxes	GTAW & GMAW Cold and Hot Wire GTAW/TIG ESW/SAW Strip Cladding
Tube Sheet 	SOUDOTAPE Strips and Record Fluxes alloy 316, 347, duplex, alloy 600, 625, 825, 59, NiCu ...	ESW/SAW Strip Cladding

JOIN! voestalpine Böhler Welding

With over 100 years of experience, voestalpine Böhler Welding is the global top address for the daily challenges in the areas of joint welding, repair, hardfacing and cladding as well as brazing. Customer proximity is guaranteed by more than 40 subsidiaries in 25 countries, with the support of 2,200 employees, and through more than 1,000 distribution partners worldwide. With individual consultation by our application technicians and welding engineers, we make sure that our customers master the most demanding welding challenges. voestalpine Böhler Welding offers three specialized and dedicated brands to cater our customers' and partners' requirements.



Lasting Connections – As a pioneer in innovative welding consumables, Böhler Welding offers a unique product portfolio for joint welding worldwide. More than 2000 products are adapted continuously to the current industry specifications and customer requirements, certified by well-respected institutes and thus approved for the most demanding welding applications. As a reliable partner for customers, “lasting connections” are the brand’s philosophy in terms of both welding and people.



Tailor-Made Protectivity™ – UTP Maintenance ensures an optimum combination of protection and productivity with innovative and tailor-made solutions. Everything revolves around the customer and their individual requirements. That is expressed in the central performance promise: Tailor-Made Protectivity™.



In-Depth Know-How – As a leading brand of soldering and brazing consumables, Fontargen Brazing offers proven solutions based on 50 years of industrial experience, tried and tested processes and methods. This In-Depth Know-How has made Fontargen Brazing an internationally preferred partner for every soldering and brazing task.

The Management System of voestalpine Böhler Welding Group GmbH, Peter-Mueller-Strasse 14-14a, 40469 Duesseldorf, Germany has been approved by Lloyd's Register Quality Assurance to: ISO 9001:2015, ISO 14001:2015, OHSAS 18001:2007, applicable to: Development, Manufacturing and Supply of Welding and Brazing Consumables. More information: www.voestalpine.com/welding



