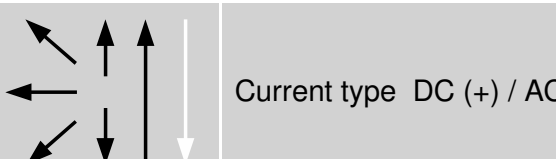


Classifications				
DIN 8555		EN 14700		
E 1-UM-350		E Fe1		
Characteristics and field of use				
<p>UTP DUR 350 is particularly suited for wear resistant surfacings on Mn-Cr-V alloyed parts, such as frogs, track rollers, chain support rolls, sprocket wheels, guide rolls etc. The deposit is still machinable with tungstene carbide tools.</p> <p>UTP DUR 350 has a very good resistance against compression and rolling strain in combination with slight abrasion. The weld metal is machinable with tungstene carbide tools.</p> <p>Hardness of the pure weld deposit                      approx. 370 HB            1 layer on steel with C = 0,5 %                      approx. 420 HB</p>				
Typical analysis in %				
C	Si	Mn	Cr	Fe
0,2	1,2	1,4	1,8	balance
Welding instruction				
<p>Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher-tensile steels to 250 – 350° C. Stick electrodes that have got damp should be redried for 2 h / 300° C.</p>				
Welding positions				
 <p>Current type DC (+) / AC</p>				
Approvals				
DB (No. 82.138.03)				
Recommended welding parameters				
Electrodes Ø x L [mm]	3,2 x 450	4,0 x 450	5,0 x 450	
Amperage [A]	100 – 140	140 – 180	180 – 230	