

**Regulation:**

DIN 8555 : E 6-UM-60-S

EN 14700 : E Fe8

**UTP DUR 600****Basic coated electrode for protector coating application in protector coating with hardness of 600 HB****Application Field**

UTP DUR 600 is an electrode with basic coating that deposits an ideal alloy for abrasion and medium/high impact demands. It can be applied in carbon cutters, bucket's lips, mill friezes' coating, prevention in manganese steels pieces (Hadfield), buckets' checking, jaws and crushers cones.

**Welding Characteristics**

UTP DUR 600 has as characteristics, few spatter, autodetaching slag and smooth cords.

**Chemical Analysis from Deposited Metal (%)**

C	Si	Mn	Cr	Fe
0.05	2.3	0.4	9.0	balance

**Mechanical Characteristics from Deposited Metal:**

- Hardness: 57 – 60 HRC
- Hardness after cooking (1h at 800° - Cooling in the oven): 28 – 32 HRS
- Oil temper at 850°: 54 HRC
- Oil Temper at 1000°: 60 HRC
- Oil Temper at 1050°C: 62 HRC

**Current Type:** CC (+)**Machine's Regulation**

Electrode Ø mm	2.5 x 300	3.25 x 350	4.0 X 450	5.0 x 450
Current A	80 – 100	100 – 140	140 – 180	180 – 230

**Welding Instructions**

Steel with Carbon rate over 0.40% must be preheated between 200° and 300° and cooled slowly after the welding. Hadfield type steels must be welded with the lesser possible heat input. If necessary, redry the electrodes during two hours at 300°C.

**WARNING:**

*The information presented herein is not a guarantee or certification for which we can be held legally responsible. These are offered to the Clients for appreciation, investigation and verification. This information may be altered without previous notice.*