

Classifications

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|----------|-------------|
| EN 14700 | DIN 8555 |
| S Fe 8 | MSG 3-GZ-60 |

Characteristics and field of use

UTP A DUR 650 is universally used for MAG buildups on structural parts subject to high impact and abrasion. Main applications are rail tamping tools, percussion tools, tool holders, shredder hammers, parts of stone treatment industry, press moulds for production of abrasive parts. Also as final layer on hard Mn-steel. Machining by grinding is possible.

UTP A DUR 650 has excellent welding properties and an even and finely rippled bead formation. Welding with low current settings if possible (e.g. cutting edges). Service temperature up to 550°C.

Hardness of the pure weld deposit: 55 – 60 HRC

Typical analysis in %

| C | Si | Mn | Cr | Mo | V | W | Fe |
|------|-----|-----|-----|-----|-----|-----|---------|
| 0.36 | 1.1 | 0.4 | 5.2 | 1.4 | 0.3 | 1.3 | balance |

Welding instruction

Grind welding area. Preheating up to 450°C, depending on the base material and wall thickness. If more than 3 layers are needed, weld buffer layers or buildups with UTP A DUR 250.

| Wire diameter [mm] | Current type | Shielding gas (EN ISO 14175) | | |
|--------------------|--------------|------------------------------|------|------|
| 1.0* | DC (+) | M 12 | M 13 | M 21 |
| 1.2 | DC (+) | M 12 | M 13 | M 21 |
| 1.6* | DC (+) | M 12 | M 13 | M 21 |

*available on request