

Classifications

DIN 8555	EN 14700
E 1-UM-250	E Fe1

Characteristics and field of use

UTP S DUR 250 is used for surfacing on parts, where a tough and easily machinable deposit is required, such as rails, gear wheels, shafts, crane wheels, track roller and other parts on farming and building machineries. Also suitable as cushion and filler layer on non-alloyed and low-alloyed steels and cast steels.

Hardness of the pure weld deposit Approx. 270HB
1 layer on steel with C = 0.5% Approx. 320HB

UTP S DUR 250 has a very good resistance against compression and rolling strain. The weld metal is easily machinable.

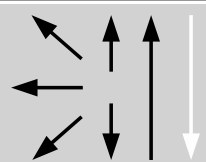
Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	Cr	Fe
0.15	1.1	1.20	0.8	Balance

Welding instruction

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher-carbon steel qualities to 150 – 300°C. Re-dry stick electrodes that have got damp for 2 hours at 300°C.

Welding positions



Current type DC (+) / AC

Approvals

-

Size, Packing and Recommended welding parameters

Size mm	Kg / Pack	Kg / Box	Amperage (A)
3.25 x 450	6.1	24.40	100 – 140
4.00 x 450	6.2	24.80	140 – 180
5.00 x 450	6.7	26.80	180 – 230