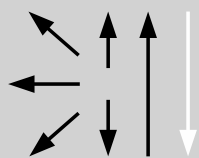


Classifications						
DIN 8555			EN 14700			
E 6-UM-60			E Fe8			
Characteristics and field of use						
UTP S DUR 650 Kb is suitable for cladding structural parts subject to abrasion combined with impact. The main applications are tools in the earth moving industry and crushing plants as well as cold and hot working tools. The deposit is only machinable by grinding.						
UTP S DUR 650 Kb is a martensitic alloy. The stick electrode is suited in impact a pressure stress situations. Machining of the weld metal only by grinding.						
Hardness of the pure weld deposit			: 57 – 60 HRC			
1 <sup>st</sup> layer on high Mn-steel			: Approx. 24 HRC			
2 <sup>nd</sup> layers on high Mn-steel			: Approx. 45 HRC			
Typical analysis of all weld metal (Wt.-%)						
C	Si	Mn	Cr	Mo	V	Fe
0.8	0.6	0.3	7.0	0.5	0.7	Balance
Welding instruction						
Hold stick electrode as vertically as possible, keep a short arc. Preheating of non-alloyed steels is not necessary. Preheat heavy parts and high-tensile base materials to 250 – 350°C. If more than 3 – 4 layers are needed, apply the softer stick electrodes UTP S DUR 250 or UTP S DUR 350 for buildup. On high Mn-steel, UTP S BMC should be used. Re-dry stick electrodes that have got damp for 2 hours at 300°C.						
Welding positions						
<div><div></div><div>Current type DC (+) / AC</div></div>						
Approvals						
-						
Size, Packing and Recommended welding parameters						
Size mm		Kg / Pack		Kg / Box		Amperage (A)
3.25 X 450		6.40		25.60		80 – 110
4.00 x 450		6.80		27.20		130 – 170
5.00 X 450		6.80		27.20		160 – 200