

Classifications

DIN 8555	EN 14700
E 10-UM-60-G	EZ Fe 1

Characteristics and field of use

UTP ABRASODUR 38 + is used for hardfacing of parts subject to heavy abrasion with moderate impact, i.e. crushing hammers, teeth and blades of shovels and bulldozers, conveyor screws, mixer blades, palm-nut etc... Service temperature up to 450°C.

UTP ABRASODUR 38 + has a quiet and regular drop transfer, can be welded in the flat and vertical-up position. 205% recovery. Stable arc, easy slag removal. Machining by grinding only.

Hardness 60 HRC.

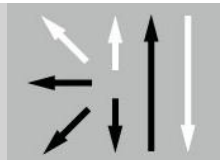
Typical analysis in %

C	Si	Mn	Cr	Fe
5,2	1,2	0,3	31,8	balance

Welding instruction

Hold the electrode vertically and keep a short arc, prepare the welding zone by polishing to metallic blank. For multi-layers, a buffer layer with UTP 630 is recommended. Re-drying: 1 hour at 300°C.

Welding positions



Current type: DC (+) / AC

Electrodes Ø x L [mm]	3,2 x 350	4,0 x 450	5,0 x 450
Amperage [A]	110 - 140	160 - 190	220 - 260