UTP DUR 300

Basic stick electrode, cladding

Classifications	
EN 14700	**DIN 8555**
E Fe 1	E 1-UM-300

Characteristics and typical fields of application

Basic coated electrode for cladding. Builds a medium hard and ductile surface, resistant against rolling abrasion.

Especially suitable for high strength base materials e.g. Mn-Mo-alloyed railway parts up to 850 MPa.

Bogie wheels, gear components, axles and so on. All weld metal is suitable for metal cutting.

Good resistance against compressive stress and rolling abrasion.

Base materials

Steels with yield strength ≤ 850 MPa (52 ksi)

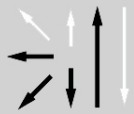
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Cr
wt.-%	0.06	0.7	1.0	3.0

Mechanical properties of all-weld metal

	Hardness
All weld metal	ca. 300 HB
1st layer on steel with C = 0.5%	ca. 350 HB

Operating data



Polarity:	Re-drying:	Electrode identification:	ø (mm)	L mm	Amps A
DC (+)	2 h/300 °C	UTP DUR 300 E Fe 1	3,2	450	110 – 130
			4,0	450	140 – 160
			5,0	450	170 – 200

Welding instruction: Stick electrode should be welded with a steep angle on a short arc. High strength steels should be pre-heated at 250 – 350 °C.

Approvals

DB (10.138.04)