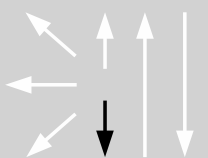


Classifications				
DIN 8555		EN 14700		
E 10-UM-60-GRZ		E Fe14		
Characteristics and field of use				
<p>UTP LEDURIT 60 is universally applicable on parts predominantly subject to grinding abrasion combined with light impact, such as conveyor screws, digging teeth, sand pumps and mixer wings. It is also suited as a final layer on tough-hard deposits (UTP DUR 600) or high Mn-steel (UTP BMC).</p> <p>UTP LEDURIT 60 has excellent welding characteristics and a very easy slag removal. The homogeneous and finely-rippled seam surface does, for most applications, not require any finishing by grinding.</p> <p>Hardness of the pure weld metal: approx. 60 HRC            1<sup>st</sup> layer on steel with C = 0.15%: approx. 55 HRC            1<sup>st</sup> layer on high Mn-steel: approx. 52 HRC</p>				
Typical analysis in %				
C	Si	Cr	Fe	
3.0	1.3	29.0	balance	
Welding instruction				
<p>Keep an angle of 80-90° between plate and electrode, and keep a short arc. Preheating is in general not necessary. On multipass-welds, a cushion layer with UTP 630 is recommended to prevent hardening cracks in the weld deposit. Re-dry damp stick electrodes for 2 hours / 300°C.</p>				
Welding positions				
		Current type DC (+) / AC		
Recommended welding parameters				
Electrodes Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 450*
Amperage [A]	50-80	90-120	120-150	150-200
*available on request				