

Classifications

DIN 8555	EN 14700	AWS A5.13
E 20-UM-45-CSTZ	E Co2	E CoCr-A

Characteristics and field of use

UTP SOUDOSTEL HR6 is used for hardfacing on parts subject to a combination of erosion, corrosion, cavitation, impact, pressure, abrasion and high temperatures up to 900° C, such as tight surfaces on fittings, valve seats and cones for combustion engines, gliding surfaces metal-metal, highly-stressed hot working tools without thermal shock, milling mixers and drilling tools.

Excellent gliding characteristics, easy polishability, good toughness, nonmagnetic. Machining by grinding or with tungsten carbide cutting tools.

Hardness of the pure weld deposit 42 HRC

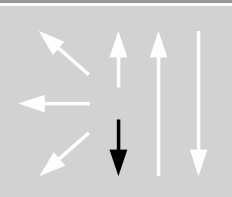
Typical analysis in %

C	Cr	Ni	W	Fe	Co
1.1	29.0	0.3	4.5	2.5	balance

Welding instruction

Clean welding area, preheating temperature 450 – 600° C, very slow cooling. Hold stick electrode as vertically as possible and weld with a short arc. Redry stick electrodes that have become damp for 2 h / 300°C.

Welding positions



Current type DC (+) / DC (-) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 350*	3,2 x 450*	4,0 x 450*
Amperage [A]	75 - 90	100 -130	130 - 160

* available on request