UTP AF ROBOTIC 405 B

gas-shielded flux-cored wire

Classifications	
DIN 8555	EN 14700
MSG 5 – GF – 40 - P	T Fe 7

Characteristics and field of use

UTP AF ROBOTIC 405 B is a seamless medium-alloyed basic flux-cored wire with low carbon content for wear-resistant surfacing applications. For steels that are difficult to weld, a buffer layer using UTP AF 155 flux-cored wire should be applied.

Thanks to its constant wire feed and excellent weldability, this flux-cored wire is especially suited for automated welding.

Application field: Parts of earth moving machinery, rollers and supports.
Machinable with sintered hard metal (e.g. WIDIA).

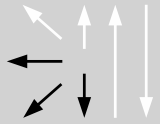
Typical analysis in %

C	Mn	Si	Cr	Mo
0.1	1.5	0.6	5.5	0.9

Typical mechanical properties

Hardness as welded: 37-42 HRC

Welding positions



Current type: = +

Shielding gas: Ar/CO_2 (EN ISO 14175: M21)
Flow rate: 14-20 l/min

Recommended welding parameters

Diameter [mm]	Spool	Weight [kg]	Amperage [A]	Voltage [V]
1.2	B300	16	120-300	20-32
1.4	B300	16	150-320	20-31
1.6	B300	16	180-420	22-34
2.0	B300	16	170-450	25-35
2.4	B300	16	200-450	25-35

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.