UTP AF ROBOTIC 606 B

gas-shielded flux-cored wire

Classifications	
DIN 8555	EN 14700
MSG 6 – GF – 60 – P	T Fe 6

Characteristics and field of use

UTP AF ROBOTIC 606 B is a seamless, basic, CrMo-alloyed wire for wear-resistant surfacing applications up to 700°C. For steels that are difficult to weld, a buffer layer using UTP AF 155 should be applied.

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

Application field: Parts of earth moving machinery, mills, crushers and supports.

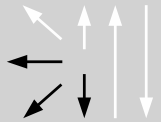
Typical analysis in %

C	Mn	Si	Cr	Mo
0.5	1.5	0.6	6.0	0.5

Typical mechanical properties

Hardness as welded: 57 – 62 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]	Spools	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.