UTP UP 73 G 2

SAW solid wire

Classifications		
EN 14700	DIN 8555	Material-No.
SZ Fe8	UP 3-GZ-50-T	Special Alloy

Characteristics and field of use

The SAW wire UTP UP 73 G 2 is used for high wear resistant buildups on construction parts and tools subject to high abrasion and pressure in combination with medium impact loads at elevated performance temperatures, e. g. forging tools, roll mandrills, mangle rolls, thrust rolls as well as for the production of high-grade work surfaces made of non- or low alloyed base materials.

Machinable by grinding or hard metal alloys.

Hardness of the pure weld deposit:

untreated:	48-52 HRC
tempered 550 °C:	approx. 55 HRC

Typical analysis in %

C	Si	Mn	Cr	Mo	Ti	Fe
0,35	0,3	1,2	7,0	2,0	0,3	balance

Welding instruction

Clean welding area to metalic bright. Preheat massive construction parts and tool steels to 250-400 °C, if necessary stress relief annealing at 550 °C. Slow cooling.

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Travel Speed [cm/min]
3,0*	400-500	28-30	30-50

*available on request

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.