UTP UP 73 G 3

SAW solid wire

Classifications		
EN 14700	DIN 8555	Material-No.
S Fe 3	UP 3-GZ-40-T	Special Alloy

Characteristics and field of use

Due to the excellent hot wear resistance and toughness, the wire UTP UP 73 G 3 is used for highly stressed surfacings on hot working tools which are simultaneously subject to high mechanical, thermal and abrasive loads, such as forge saddles, rolls, rotors, hot-shear blades.

Machining with hard metal alloys.

Hardness of the pure weld metal:

untreated:	38-42 HRC
tempered at 550 °C:	approx. 45 HRC

Typical analysis in %

C	Si	Mn	Cr	Mo	Ti	Fe
0,25	0,5	0,7	5,0	4,0	0,6	balance

Welding instruction

Clean welding area to metallic 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]
2,4*	300-350	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.