UTP UP 73 G 4

SAW solid wire

Classifications		
EN 14700	DIN 8555	Material-No.
SZ Fe3	UP 3-GZ-350-T	Special Alloy

Characteristics and field of use

Due to the good hot wear resistance and toughness, the wire UTP UP 73 G 4 is used for surfacings on hot working tools and construction parts, which are subject to impact, pressure and abrasion at elevated temperatures, such as rolls, running wheels, guidings, recipients, drums. Hot wear resistant claddings can be made on non- and low alloyed base materials.

The weld deposit is machinable.

Hardness of the pure weld deposit: 32-35 HRC

Typical analysis in %

C	Si	Mn	Cr	Mo	Fe
0,1	0,4	0,6	6,5	3,3	balance

Welding instruction

Clean welding area to metallic bright, cracks in the tool have to be gouged out completely. Preheating temperature of 400 °C on tools should be maintained, stress relief, if necessary, at 550 °C. Preheating to 150 °C generally on non-and low alloyed materials.

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Travel Speed [cm/min]
2,4*	300-350	28-30	30-50
3,0*	320-450	28-30	30-50
4,0*	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.