UTP UP DUR 250

SAW solid wire

Classifications		
EN 14700	DIN 8555	Material-No.
SZ Fe1	UP 1-GZ-250	1.8401

Characteristics and field of use

The SAW wire UTP UP DUR 250 is used for submerged arc welding on construction parts, where resistance against rolling wear and a good machinability is required, such as surfacings on rail crossings, couplings, wobbler drives, crane wheels, shafts and gear parts.

Hardness of the pure weld deposit: approx. 250 HB

Typical analysis in %

C	Si	Mn	Cr	Ti	Al	Fe
0,3	0,4	1,0	1,0	0,2	0,1	balance

Welding instruction

Clean welding area to metallic bright.
Preheat massive parts to 150 °C, cooling down slowly.

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Travel Speed [cm/min]
3,0*	400-500	28-30	30-50
4,0*	500-600	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.