# UTP 67 S

Basic coated hardfacing stick electrode for cold working tools, core wire alloyed

| DIN 8555 | EN 14700 |
|---|---|
| E 6-UM-60-S | E Fe8 |

## Application field

UTP 67 S is universally applicable on workpieces of steel, cast steel or hard Mn-steel, subject to a combination of impact, compression and abrasive wear, such as radial cams, drums, bearing surfaces, wheel rims, rollers, tires, rails, switch blades, gear wheels, plough blades, stamping mills, crusher jaws, beaters, excavator parts, rope pulleys, baffle plates, block machines etc.

A specialized area in which UTP 67 S has given excellent results is the building-up of cutting edges of cold cutting tools (Cr cutting steels) in the car industry.

## Welding properties

Smooth arc, regular and smooth seam surface, especially when building-up edges. Easy slag removal. Slag removal is not required for multi-pass applications.

## Hardness of pure weld deposit

| | |
|---|---|
| Hardness of pure weld deposit: | 56–58 HRC |
| After soft-annealing (820°C/oven): | approx. 25 HRC |
| After hardening (850°C/oil): | 52-54 HRC |
| After hardening (1000°C/oil): | 60-62 HRC |

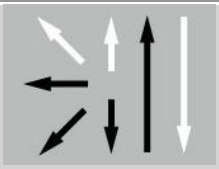
| C | Si | Mn | Cr | Fe |
|---|---|---|---|---|
| 0.5 | 3.0 | 0.5 | 9.0 | balance |

## Welding instruction

Hold stick electrode as vertically as possible and keep a short arc. Pre-heating is only necessary for surfacing higher-carbon materials, for tool steels a temperature of 300-400°C is required.

Re-dry stick electrodes that have got damp for 2h/300°C.

## Welding positions



Current type = + / = - / ~

| Stick electrodes Ø x L [mm] | 2.5 x 300 | 3.2 x 350 | 4.0 x 350 | 5.0 x 450 |
|---|---|---|---|---|
| Amperage [A] | 50-70 | 70-100 | 110-140 | 140-170 |

Sämtliche angegebenen Informationen basieren auf sorgfältiger Ermittlung und umfangreichen Recherchen. Wir übernehmen jedoch keine Gewährleistung und Haftung für die Richtigkeit der Angaben und Änderungen sind vorbehalten.