UTP 670

Basic-coated stick electrode for hardfacings
resistant to impact, compression and abrasion

Classifications	
DIN 8555	EN 14700
E 6-UM-60	E Fe8

Characteristics and field of use

UTP 670 is a high-efficiency stick electrode for hardfacing of workpieces made of steel, cast steel or high Mn-steel, subject to simultaneous wear by impact, compression and abrasion.

Typical applications are crane wheels, rollers, chain links, sprocket wheels, gliding surfaces, screw conveyors, beaters, edge runners, guide wheels, baffle plates etc.

In tool shops this electrode is especially suitable for repair welding of cutting knives, stamps, punches, shear blades or forming tools. UTP 670 can also be used to weld Vanadium-alloyed tool steels.

Properties of the weld metal

UTP 670 has a martensitic structure and is suited to hardfacings resistant to wear by impact, compression and slight abrasion.

Hardness of the pure weld deposit approx. 58 HRC

Typical analysis in %

C	Si	Mn	Cr	Mo	V	Fe
0.4	1.0	1.0	9.0	0.6	1.0	balance

Welding instructions

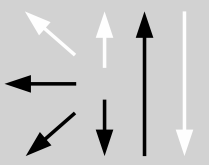
Hold stick electrode as vertically as possible and keep the arc short.

Preheating and post-weld heat treatment should be carried out depending on wall thickness, geometry, base metal and general requirements. For multi-pass applications it is advisable to weld buffer layers with UTP DUR 250/UTP 73 G4 and apply UTP 670 for the last 3 layers.

Depending on the requirements, high preheating of high Mn-steels or un-alloyed steels may not be mandatory.

Electrodes should be redried for 2 h/300°C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 350	3.2 x 450	4.0 x 450	5.0 x 450*
Amperage [A]	70 – 90	90 – 120	130 – 160	170 - 210

* 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.