UTP 700

Rutile-coated stick electrode on NiCrMoW base
for highly heat-resistant hardfacings on hot working tools

Classifications		
DIN 8555	**EN 14700**	**AWS A5.11**
E 23-UM-200-CKTZ	EZ Ni2	~E NiCrMo-5

Characteristics and typical fields of application

UTP 700 is suited for wear-resisting claddings on hot working tools subject to thermal load, such as forging dies, hot piercing plugs, hot cutting knives and press rams, as well as for highly corrosion-resistant claddings, such as e.g. flat faces of armatures.

UTP 700 shows excellent welding properties, a stable spray arc with a finely ripped seam surface and a very easy slag removal. The weld deposit is heat-resistant and highly corrosion-resistant, scale-resistant and work hardening, machinable with cutting tools.

Hardness: approx. 280 HB

Typical analysis of all-weld metal (wt.-%)

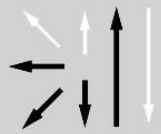
C	Si	Mn	Cr	Mo	Ni	W	Fe
0.15	1.0	1.0	17.0	18.0	balance	4.5	5.5

Welding instruction

Clean welding area to metallic brightness. Preheat tools, depending on base metal, to 200 – 400°C, hold this temperature during welding. Slow cooling. Hold stick electrode as vertically as possible and weld with a short arc. Select lowest possible amperage in order to prevent dilution with the base metal.

Re-drying: 2 hours / 300°C.

Operating data



Current type: DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 300	3.2 x 300	4.0 x 350
Amperage [A]	45 - 90	70 - 110	100 - 150

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.