UTP 7100

High-efficiency stick electrode without slag,
resisting abrasion and low impact loads.
Recovery 180%

Classifications	
EN 14700	DIN 8555
E Z Fe14	E 10-UM-65-GRZ

Characteristics and field of use

The high Cr-C-alloyed hardfacing stick electrode **UTP 7100** is used for surfacings on parts made of carbon steel, cast steel or Mn-steel, which are subject to grinding wear, such as idlers, digging buckets, digging teeth, ploughshares, mixing wings and conveyor screws.

On Mn-hard steels it is advisable to weld the building-up layers with UTP 630 or UTP 7200.

Hardness of the pure weld deposit: 60 - 63 HRC
First layer on S355: 55 HRC

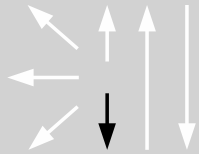
Typical analysis in %

C	Cr	Fe
5.0	35.0	balance

Welding instructions

Hold stick electrode as vertically as possible and weld with a short arc. The weld deposit has high hardness values already in the first layer due to low dilution with the base metal.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	3.2 x 350	4.0 x 350	5.0 x 450
Amperage [A]	110 – 160	150 – 200	180 - 240

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.