UTP 7200

basic-coated, CrNi-alloyed, Mn-hardsteel stick electrode

Classifications		
DIN 8555	EN 14700	AWS A5.13
~ E 7-UM-250-KP	EZ Fe9	~ E FeMn-C

Characteristics and field of use

UTP 7200 is predominantly suitable for tough and crack-resistant joinings and surfacings on parts of high Mn-steel subject to extreme impact, compression and shock. Build-ups on C-steel are also possible. The main application areas are the building industry, quarries and mines for surfacing worn high-Mn steel parts, e.g. excavator pins, buckets and teeth, mill hammers, crusher jaws, cones and beaters, impeller bars, railway building machinery, shunts, heart and cross pieces.

The high Mn-content produces a fully austenitic deposit. The deposit is highly work-hardening and hardens during service from originally 200 – 250 HB to 450 HB. Machining is possible with tungstene carbide tools.

Hardness of the pure weld deposit

As welded:	200 – 250 HB
After work-hardening:	48 – 53 HRC

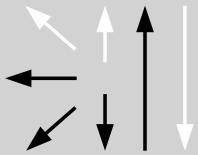
Typical analysis in %

C	Mn	Ni	Cr	Fe
0.7	13.0	4.0	4.5	balance

Welding instructions

Hold stick electrode as vertically as possible. Weld at a low temperature and keep interpass temperature below 250° C. It is recommended to weld short beads and to allow for continuous cooling during welding; you may also place the workpiece in a cold water bath and have only the welding area stand out of the water.

Welding positions



Current type DC (+) / AC

Approvals

DB (No. 20.138.08)

Recommended welding parameters

Electrodes Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Amperage [A]	110 – 140	150 – 180	180 – 210

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.