# UTP 75

Graphite basic-coated stick electrode with sintered core wire on tungsten-carbide base, against extreme mineral abrasion

| Classifications | |
|---|---|
| DIN 8555 | EN 14700 |
| E21-UM-65-G | EZ Fe20 |

## Characteristics and field of use

UTP 75 is, thanks to its high hardness, particularly suited for hardfacing of parts subject to extremely severe mineral abrasion with very low impact stress, such as sand mixer blades, conveyor screws in the ceramics industry, earth drills, injection screws of brick moulding machines, teeth and bars of grates in the steel industry, bucket and shovel teeth, strippers on asphalt processing machines, trench milling tools.

## Welding properties

UTP 75 has a smooth and stable arc and a self-removing slag. The smooth bead surface does normally not require any machining by grinding with silicon carbide or diamond wheels.

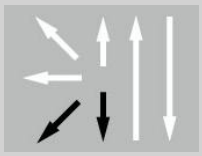
Hardness of the pure weld deposit: approx. 65 HRC
Microhardness of the tungsten carbides: approx. 2500 HV

| Weld metal analysis in % | | |
|---|---|---|
| WC | CrC | Fe |
| 70.0 | 10.0 | balance |

## Welding instruction

Keep an angle of 80-90° between plate and electrode, make slightly weaving beads, keep a short arc. Preheating is generally not necessary. Apply max. 2 layers. Re-dry damp electrodes for 2 h / 300°C.

## Welding positions



Current type DC (-) / AC

| Recommended welding parameters | | |
|---|---|---|
| Electrodes Ø x L [mm] | 4.0 x 300 | 5.0 x 300* |
| Amperage [A] | 110 – 140 | 140 - 170 |

*available on request