UTP 807

Special stick electrode without nickel for machinable surfacings

Classifications

EN ISO 1071

E C Z Fe-2

Characteristics and field of use

UTP 807 is suited for fabrication and maintenance work on lamellar cast iron and nodular cast iron. Depending on the wall thickness ratio, it can be welded without preheating or with a preheating temperature of 150 - 250° C. The Fe-based weld metal can already be filed in the first layer.

This electrode is specifically designed for repair works on new or worn cast iron parts, if similarity in color and post-weld machinability are required. Thanks to the special microstructure of the weld metal, **UTP 807** is especially suitable for hardfacings of wear-susceptible areas of grey cast iron parts.

Welding properties

UTP 807 has good welding properties and is welded in stringer bead technique. Little penetration and a good weld build-up allow out-of-position welding.

Typical analysis in %

C	Si	Mn	V	Fe
0.05	0.4	0.5	10.0	balance

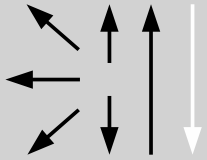
Hardness

Approx. 180 HB
Approx. 230 HB (1 layer on GJL-250/GG 25)

Welding instructions

Machine the welding area to a metallic bright finish. Weld with short arc length and without weaving. Overlap widely to avoid heat accumulation (max. 60 °C).

Welding positions



Current type DC (+)

Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 350*	3.2 x 350
Amperage [A]	60-80	80-120

* 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.