UTP ABRASODUR 43 +

Basic-coated electrode for hardfacing.
Recovery 190 %.

Classifications	
DIN 8555	DIN EN 14700
E 10-UM-65-GR	EZ Fe 15

Characteristics and field of use

UTP ABRASODUR 43+ is used for hardfacing of parts subject to heavy abrasion with moderate impact, i.e. cement presses, brick presses, refactory press-screws, conveyor screws, mixer blades, palm-nut etc…Service temperature up to 450°C.

Welding properties

UTP Abrasodur 43+ has a quiet and regular drop transfer, can be welded in flat and vertical-up position. 190% recovery. Stable arc, easy slag removal. Machining by grinding only.

Hardness	
1 layer	62 HRC
2 layers	63 HRC

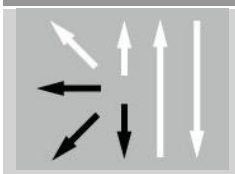
Typical weld metal analysis in %

C	Si	Mn	Cr	Nb	Fe
6.5	1.5	1.5	24.5	7.0	balance

Welding instruction

Hold the electrode vertically and keep a short arc, prepare the welding zone by polishing to metallic blank. For multi-layers, a buffer layer with UTP 630 is recommended. Re-drying: 1 hour at 300°C.

Welding positions



Current type: DC (+) / AC

Electrodes Ø x L [mm]	3,2 x 350	4,0 x 450	5,0 x 450
Amperage [A]	110 - 140	140 - 190	190 - 250

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.