UTP ABRASODUR 45 +

Basic-coated high-efficiency electrode against extreme abrasion.
Recovery 250 %.

DIN EN 14700

E Fe 16

Characteristics and field of use

UTP Abrasodur 45+ is suited for highly abrasion-resistant claddings on parts subject to extreme mineral abrasion, also at elevated temperatures up to 500°C. The extremely high abrasion resistance is achieved by the very high content of special carbides (Cr, V, W, Nb).
Main applications: Surfacing on earth moving equipment, working parts in the cement and brick industry as well as in steel mills for radial breakers and revolving-bar screens of sintering plants.

Welding properties

UTP Abrasodur 45+ has an even droplet transfer in the spray arc. The smooth welding bead is not covered by slag, so in general there is no need for any finishing by grinding.

Hardness

Hardness of the pure weld deposit	approx. 65 HRC
1 layer on steel with C = 0.15%	approx. 58 HRC
1 layer on Mn-steel	approx. 55 HRC

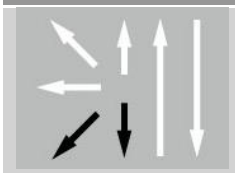
Typical weld metal analysis in %

C	Mn	Si	Cr	Mo	Nb	W	V	Fe
5.8	0.3	1.9	21	6.0	6.0	2.5	1.2	balance

Welding instruction

Hold the electrode as vertically as possible, keeping a short ac. Reduce dilution with base material by welding stringer beads. For multipass applications a buffer layer with UTP 630 is recommended. Re-dry electrodes that have got damp for 2 h / 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]	125-155	140-190	210-290

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.