UTP CELSIT 712

Rutile-coated stick electrode on cobalt base, core-wire-alloyed

Classifications		
EN 14700	AWS A5.13	DIN 8555
E Co3	E CoCr-B	E 20-UM-50-CSTZ

Characteristics and field of use

UTP CELSIT 712 is used for highly wear-resistant hardfacings on parts subject to a combination of abrasion, erosion, cavitation, corrosion, pressure and high temperatures up to 900° C, such as running, sealing and gliding faces on fittings and pumps; tools for wood, paper, plastic; shredding tools; highly stressed hot-working tools not subject to thermal shock.

Properties of the weld metal

Machining by grinding or with tungsten carbide cutting tools.

Welding properties

UTP CELSIT 712 has excellent welding properties and a homogeneous, finely rippled seam. Very easy slag removal.

Hardness of the pure weld deposit

Hardness at RT: 48 - 50 HRC
Hardness at 500° C: approx. 40 HRC
Hardness at 700° C: approx. 33 HRC

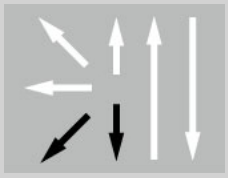
Typical analysis in %

C	Cr	W	Co
1.6	29.0	8.5	balance

Welding instructions

Clean welding area, preheating temperature 500-600°C, very slow cooling. Hold stick electrode vertically, weld with a short arc and lowest possible amperage. Re-dry damp stick electrodes for 2 h/300°C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters		
Electrodes Ø x L [mm]	3.2 x 350	4.0 x 350
Amperage [A]	70 – 110	90 - 130

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.