UTP CELSIT 721

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

Classifications		
DIN 8555	EN 14700	AWS A5.13
E 20-UM-350-CTZ	E Co1	E CoCr-E

Characteristics and field of use

UTP CELSIT 721 is used for crack-resistant hardfacings on parts subject to a combination of impact, pressure, abrasion, corrosion and high temperatures up to 900° C, such as running and sealing faces on gas, water, steam and acid fittings and pumps, valve seats and cones for combustion engines, working parts in gas and power plants, hot-working tools with changing thermal load.

Excellent gliding characteristics, good polishability and toughness, highly work-hardening, nonmagnetic, machinable with cutting tools.

UTP CELSIT 721 has excellent welding properties and a homogenous, finely-rippled seam. Very easy slag removal.

Hardness of the pure weld metal:	31 – 37 HRC
Work-hardened:	approx. 45 HRC
Hardness at 600°C:	approx. 240 HB

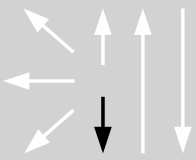
Typical analysis in %

C	Cr	Mo	Ni	Co
0.3	31.0	5.0	3.5	balance

Welding instructions

Clean welding area, preheating temperature 150 – 400° C, depending on the size of the work piece and the base material. Slow cooling. Hold stick electrode vertically and 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]	80 – 120	110 – 140

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.