UTP CHRONOS

Basic-coated high-Mn-steel stick electrode
for claddings exposed to compression and shock

Classifications	
DIN 8555	EN 14700
E 7-UM-200-KP	E Fe9

Characteristics and field of use

UTP CHRONOS is suitable for build-ups on high-Mn-steel of the same and similar nature and on C-steels. Main applications are the re-conditioning of crusher jaws and cones, excavator teeth and buckets, edge mills and runners, railway units.

Fully austenitic structure, tough, with strong tendency to workhardening under pressure and shock. Machinable only with tungsten carbide tools or by grinding.

Hardness of the pure weld deposit:

As-welded condition: approx. 220 HB

After workhardening: 50 – 55 HRC

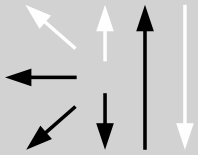
Typical analysis in %

C	Si	Mn	Fe
0.9	0.8	13.0	balance

Welding instruction

Hold stick electrode as vertically as possible. Welding should be done at lowest possible temperature. Interpass temperature should not exceed 250°C. It is therefore recommended to weld short beads and to allow for intermediate cooling, or to place the workpiece in a cold-water bath, having only the weld area stick out. Damp electrodes should be re-dried for 2 h / 300°C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	3.2 x 450	4.0 x 450
Amperage [A]	120 – 150	150 - 180

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.