UTP DUR 400

Basic coated, high-efficiency welding stick electrode
for crack and wear resistant surfacings. Recovery 200 %.

Classifications	
DIN 8555	EN 14700
E 1-UM-400	E Z Fe1

Characteristics and field of use

UTP DUR 400 is used for surfacing parts of non-alloyed and low-alloyed steel and cast steel, subjected mainly to pressure and shock, such as rolls, couplings, stamps, hammers, guide rails etc.

UTP DUR 400 has a good resistance against impact and pressure wear with low abrasion. The weld metal is machinable with carbide cutting tools and temperature resistant up to 350°C.

Hardness of the pure weld deposit	approx. 450 HB
1 layer on steel with C = 0,5 %	approx. 500 HV
1 layer on steel with C = 0,12 %	approx. 380 HB

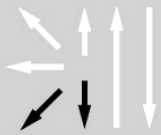
Typical analysis in %

C	Si	Mn	Cr	Mo	Fe
0,13	1,5	4,0	1,5	0,5	balance

Welding instruction

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher-tensile steels to 250 – 350° C. Stick electrodes that have got damp should be redried 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	5,0 x 450
Amperage [A]	120 – 160	140 – 190	190 – 260

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.