UTP HydroCav

basic-coated stainless stick electrode against cavitation wear

Classifications	
DIN 8555	EN 14700
E 5-UM-250-CKZT	EZ Fe9

Characteristics and field of use

UTP HydroCav is suitable for wear-resistant surfacings with high resistance to cavitation, corrosion, pressure and impact, especially in the construction of water turbines and pumps. Thanks to a high work-hardening rate, the weld deposit will double its hardness values under impact stress. The main application field is surfacing of soft martensitic 13/4 CrNi-steels on Kaplan turbine blades.

UTP HydroCav has good welding properties and is weldable in all positions, except vertical-down. It shows a stable arc, an even weld build-up and easy slag removal.

Hardness of the pure weld deposit:

as-welded: approx. 21 HRC

after work-hardening: approx. 50 HRC

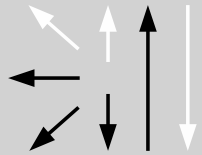
Typical analysis in %

C	Si	Mn	Cr	Ni	Co	Fe
0.2	0.7	10.0	20.0	0.15	13.0	balance

Welding instructions

Clean welding area thoroughly to a metallic bright finish. The interpass temperature should not exceed 250°C. Preheating of heavy work pieces to 80 – 100°C is recommended. Hold stick electrode vertically and weld with short arc. Re-baking: 2h/300° C

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 250	3.2 x 350	4.0 x 350
Amperage [A]	70 – 90	90 – 120	120 – 150

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.