UTP SOUDOSTEL HR21

rutile-coated stick electrode on cobalt base
Recovery: 150%

Classifications		
DIN 8555	EN 14700	AWS A5.13
E20-UM-35-CKTZ	E Co1	E CoCr-E

Characteristics and field of use

UTP SOUDOSTEL HR21 is used for hardfacing on parts subject to a combination of erosion, corrosion, cavitation, impact, pressure, abrasion and high temperatures up to 900° C, such as tight surfaces on fittings, valve seats and cones for combustion engines, gliding surfaces metal-metal, highly-stressed hot working tools with thermal shocks.

Excellent gliding characteristics, easy polishability, good toughness, nonmagnetic. Machining by cutting tools.

Hardness of the pure weld deposit	32 HRC
Work hardened	45 HRC

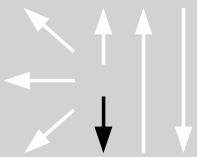
Typical analysis in %

C	Cr	Ni	Mo	Fe	Co
0.3	28.0	2.7	4.5	3.5	balance

Welding instruction

Clean welding area, preheating temperature 150 – 400° C, very slow cooling. Hold stick electrode as vertically as possible and weld with a short arc. Redry stick electrodes that have become damp for 2 h / 300°C.

Welding positions



Current type DC (+) / DC (-) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 350*	3,2 x 450*	4,0 x 450*
Amperage [A]	75 - 90	100 -140	140 - 180

*available on request

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.