UTP SOUDOSTEL HR25

Rutile-coated stick electrode on cobalt base
Recovery: 195%

Classifications	
EN 14700	DIN 8555
EZ Co1	E20-UM-250-CPTZ

Characteristics and field of use

UTP SOUDOSTEL HR25 is used for production and repair of hot-working tools subject to extreme temperatures, thermal shock, compression, impact and abrasion. Main application fields are hot dies, hot pressing blades, hot trimming tools and roll mandrils.

Welding properties and special properties of the weld deposit

The weld deposit is highly corrosion- and scaling-resistant, has a high work-hardenability and is heat-resistant up to 900° C. Machinable with cutting tools.

Hardness of the pure weld deposit:

As welded : approx. 230 HB

Typical analysis in %

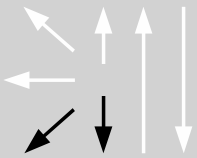
C	Si	Mn	Cr	Ni	W	Co	Fe
0.03	1.1	1.6	21.0	11.0	17.0	balance	2.0

Welding instructions

Clean welding area, preheat tools to 350 - 400° C and maintain this temperature during the whole welding process. Hold stick electrode vertically and weld with a short arc. Select lowest possible amperage in order to reduce dilution with the base metal.

Re-dry damp stick electrodes for 2h/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]	40 – 55	55 – 90	100 – 140

*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.