

UTP 67 S

Standards :

DIN 8555 : E 6-UM-60-S
 EN 14700 : E Fe8

Basic coated hardfacing stick electrode for cold working tools, core wire alloyed

Application field

UTP 67 S is universally applicable on workpieces of steel, cast steel or hard Mn-steel subject to a combination of impact, compression and abrasive wear, such as radial cams, drums, bearing surfaces, wheel rims, rollers, tires, rails, switch blades, gearwheels, plough blades, stamping mills, crusher jaws, beaters, excavator parts, rope pulleys, baffle plates, block machines etc. A specialized area in which **UTP 67 S** has given excellent results is the building-up of cutting edges of cold cutting tools (Cr cutting steels) in the car industry.

Welding properties

Smooth arc, regular and smooth seam surface, especially when building-up edges. Easy slag removal. Slag removal is not required on multi-pass applications.

Hardness of the pure weld deposit		56 - 58 HRC
after soft-annealing	820° C/oven	approx. 25 HRC
after hardening	850° C/oil	52 - 54 HRC
	1000° C/oil	60 - 62 HRC

Weld metal analysis in %

C	Si	Mn	Cr	Fe
0,5	3,0	0,5	9,0	balance

Welding instruction

Hold stick electrode as vertically as possible and keep a short arc. Preheating is only necessary for surfacing higher-carbon materials, for tool steels a temperature of 300 - 400° C is required. Re-dry stick electrodes that have got damp for 2h/300° C.

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

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 300	3,2 x 350	4,0 x 350	5,0 x 450
Amperage	A	50 - 70	70 - 100	110 - 140	140 - 170

