

## UTP 670

### Standards :

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

**Basic coated hardfacing stick electrode resisting impact, compression and abrasion**

### Application field

**UTP 670** is a high-efficiency stick electrode for hardfacing workpieces of steel, cast steel or high Mn-steel, subject to simultaneous wear by impact, compression and abrasion. Due to its recovery, this stick electrode is ideally suited for economic one-layer applications. Typical applications are crane wheels, rollers, chain links, sprocket wheels, gliding surfaces, screw conveyors, beaters, edge runners, guide wheels, baffle plates etc.

### Properties of the weld metal

**UTP 670** has a martensitic structure and is suited for impact and compression wear and slight abrasion.

**Hardness of the pure weld deposit** approx. 58 HRC

### Weld metal analysis in %

C	Si	Mn	Cr	Mo	V	Fe
0,4	1,0	1,0	9,5	0,6	1,5	balance

### Welding instruction

Hold stick electrode as vertically as possible and keep a short arc. Preheating is generally not necessary. For multipass applications it is advisable to weld cushion layers with UTP DUR 250 and to apply UTP 670 for the last 3 layers. Preheating temperature of high Mn-steels should not exceed 250° C, if necessary intermediate cooling or welding in a water bath. Stick electrodes that have got damp should be redried for 2 h / 300° C.

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

**Welding positions**



### Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 350*	3,2 x 450	4,0 x 450	5,0 x 450
Amperage	A	50 – 70	90 – 120	130 – 160	170 – 210

\* available on request

