

UTP 700

Standards :

DIN 8555	:	E 23-UM-200-CKTZ
EN 14700	:	E Ni2
AWSA5.11	:	E NiCrMo-5

Rutile coated stick electrode on NiCrMoW base for high heat resistant hardfacings on hot working tools, core wire alloyed

Application field

UTP 700 is suited for wear resisting cladding on hot working tools subject to thermal load, such as forging dies, hot piercing plugs, hot cutting knives and press rams. For high-corrosion resistant claddings, such as e.g. flat faces of armatures.

Welding properties

UTP 700 has excellent welding properties, stable spray arc with finely rippled seam surface and very easy slag removal. The weld deposit is heat resistant and highly corrosion resistant, scale resistant and workhardening. Machinable with cutting tools.

Hardness of the pure weld metal: approx. 280 HB

Weld metal analysis in %

C	Si	Mn	Cr	Mo	Ni	W	Fe
0,15	1,0	1,0	17,0	18,0	balance	4,5	5,5

Welding instruction

Clean welding area to metallic bright. Preheating tools to 350 – 400° C, temperature should be maintained. Slow cooling. Hold stick electrode as vertically as possible and with a short arc. Select lowest possible amperage, in order to prevent mixing with the base metal. Re-dry electrodes that have got damp for 2 h / 300° C.

Current type DC (+) / AC

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 250*	3,2 x 300	4,0 x 350
Amperage	A	45 – 90	70 – 110	100 – 150

* available on request

