

Classifications

DIN 8555	EN 14700
E 23-UM-200-CKTZ	E Z Ni 2

Characteristics and field of use

UTP 7000 is particularly suited for wear resisting cladding on working surfaces of hot working tools subject to thermal load, such as forging jaws, forging dies, forging saddles, hot piercing plugs, hot cutting tools, hot trimming tools, roll mandrils, hot moulding plugs.

UTP 7000 has excellent welding properties, a regular and finely rippled bead appearance due to spray arc. Very easy slag removal. The weld deposit is highly corrosion resistant, scale resistant and workhardening. Machinable with cutting tools.

Hardness of the pure weld deposit : approx. 220 HB
 after workhardening approx. 450 HB

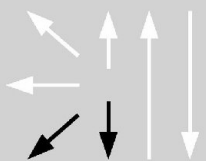
Typical analysis in %

C	Si	Mn	Cr	Mo	Ni	W	Co	Fe
0,04	0,3	0,9	16,0	17,0	balance	5,0	1,5	5,0

Welding instruction

Clean welding area, preheat tools to 350 – 400° C and maintain this temperature during the whole welding process. Slow cooling in an oven. Hold stick electrode vertically and with a short arc. Select lowest possible amperage, in order to reduce dilution with the base metal. Cracks in the tool have to be gouged out completely and welded with UTP 7015 HL or UTP 068 HH. Final layers have to be welded with UTP 7000. Redry stick electrodes that have got damp for 2h/300° C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 350	3,2 x 350	4,0 x 350	5,0 x 450
Amperage [A]	80 – 100	100 – 120	130 – 160	180 – 220

