

UTP 7100

Standards :

DIN 8555	:	E 10-UM-65-GRZ
EN 14700	:	EZ Fe14
AWS A5.13	:	~ E FeCr-A I

High-efficiency stick electrode without slag resisting abrasion and moderate impact loads. Recovery 180 %

Application field

The high Cr-C-alloyed hardfacing stick electrode **UTP 7100** is used for surfacings on parts made of constructional steel, cast steel or Mn-steel, which are subject to grinding wear, such as idlers, digging buckets, digging teeth, ploughshares, mixing wings and conveyor screws.

On multi-pass applications it is excellently suitable as buffer layer on high-strength building-up layers UTP DUR 600 or UTP 670. On Mn-hard steels it is advisable to weld the building-up layers with UTP 630 or UTP 7200.

Welding properties

UTP 7100 has excellent welding properties. The electrode is also suitable for light out-of-position weldings. Good electric loading, a very stable arc, minimal development of fume, flat and regular seam surface. High deposition rate due to the recovery of 180 %.

Hardness of the pure weld deposit	60 - 63 HRC
I. layer on St 52	55 HRC

Weld metal analysis in %

C	Cr	Fe
5,0	35,0	balance

Welding instruction

Hold stick electrode as vertically as possible and with a short arc. The weld deposit has high hardness values already in the I. layer due to a low welding amperage and as a result of a low dilution with the base metal.

Current type DC (+) / AC

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	3,2 x 350	4,0 x 350	5,0 x 450
Amperage	A	90 - 120	110 - 140	130 - 160

