

## Classifications

DIN 8555	EN 14700
E 3-UM-40-PT	E Z Fe3

## Characteristics and field of use

UTP 73 G 4 is, due to its toughness and heat resistance, ideally suited for surfacings on parts and tools subject to abrasion, compression and impact at elevated temperatures. Particularly for buildups on forging dies, die cast moulds, rollers, wobbler drives, hot-shear blades. UTP 73 G 4 also offers an economic solution for the production of new tools, for which a base material with an adequate tensile strength is recommended.

The stick electrode has excellent welding properties, a stable and regular flow, good bead appearance and very easy slag removal. Heat resistant up to 550° C.

Hardness of the pure weld metal: approx. 38 – 42 HRC

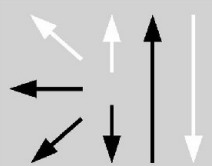
## Typical analysis in %

C	Si	Mn	Cr	Mo	Fe
0,1	0,5	0,6	6,5	3,5	balance

## Welding instruction

Preheat the workpiece to 400° C. Hold stick electrode as vertically as possible and with a short arc. Take care of a slow cooling of the workpiece. Machining is possible with tungstene carbide tools. Re-dry 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 300	3,2 x 350	4,0 x 400	5,0 x 400*
Amperage [A]	60 – 90	80 – 100	100 – 140	130 – 170

\* available on request

