

Standards :

DIN 8555 : E 21-UM-65-G
 EN 14700 : EZ Fe20

UTP 75

Graphite basic coated stick electrode with sintered core wire on tungsten-carbide base against extreme mineral abrasion

Application field

UTP 75 is, due to the high hardness, particularly suited for hardfacing of parts subject to extremely severe mineral abrasion with very low impact stress, such as sand mixer blades, conveyor screws in the ceramics industry, earth drills, injection screws of brick moulding machines, teeth and bars of grates in the steel industry, bucket and shovel teeth, strippers on asphalt processing machines, trench milling tools.

Welding properties

UTP 75 has a smooth and stable arc and a self-removing slag. The smooth bead surface does, in most cases, not require any machining by grinding with silicon carbide or diamond wheels.

Hardness of the pure weld deposit : approx. 65 HRC
 Microhardness of the tungsten carbides : approx. 2500 HV

Weld metal analysis in %

WC	CrC	Fe
70,0	10,0	balance

Welding instruction

Hold stick electrode vertically, make slightly weaving beads, keep a short arc. Preheating is generally not necessary. Apply max. 2 layers. Re-dry stick electrodes that have become damp for 2h/300° C.

Current type DC (-) / AC

Welding positions


Availability / Current adjustment

Stick electrodes	Ø mm x L	4,0 x 300	5,0 x 300*
Amperage	A	110 – 140	140 – 170

* available on request

