

Classifications

EN ISO 14343-A	EN 14700	Material-No.
G Z 17 Mo H	S Fe7	1.4115

Characteristics and field of use

UTP A 661 is used for wear resistant claddings on construction parts made of non-alloyed or low-alloyed steels and cast steels, hot working steels, high alloyed steels and cast steels, particularly for one-layerwelding. Special application fields are claddings on machine parts made of high tensile steel for hardening and tempering, hot working tools, continuous casting rolls and dummy blocks, membrane sides in coal burning power stations and parts resistant against high temperature up to 900 °C.

The martensitic weld deposit is wear resistant also at elevated temperatures. It is resistant against water, seawater, steam and diluted organic acids. High thermal strength.

Hardness of the pure weld deposit

untreated : approx. 40 HRC

one-layer-welding on C 45 : approx. 55 HRC

Typical analysis in %

C	Si	Mn	Cr	Mo	Fe
0.22	0.7	0.7	17.5	1.2	balance

Welding instruction

Welding with MIG pulsed current provides a low-in-spatter deposit of perfect appearance. The preheating must be matched to the parent metal and the welding scope, generally between 150 °C – 400 °C. Slow cooling in still air or under a cover resp. in an oven. Tempering, if necessary.

Approvals

TÜV (No. 06743)

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)			
		M 12	M 13	M 21	C 1
1.0*	DC (+)	M 12	M 13	M 21	C 1
1.2	DC (+)	M 12	M 13	M 21	C 1
1.6	DC (+)	M 12	M 13	M 21	C 1

*available on request

