

## UTP A 673

### Standards :

Material-No. : 1.2606  
 DIN 8555 : W/MSG 3-60-T  
 EN 14700 : S Z Fe3

**Wire for wear resistant surfacings on cold and hot working tools**

### Application field

**UTP A 673** is used for the repair and production of hot working tools, such as die cast moulds, forging dies, hot cutting knives, hot-shear blades, axial rolls, roll mandrils, upset plates as well as for the production of working surfaces on non-alloy and low-alloy base materials.

### Properties of the weld metal

Machining is possible with tungstene carbide tools.

### Hardness of the pure weld deposit:

untreated 53 - 58 HRC  
 soft annealed 820° C approx. 230 HB  
 hardened 820° C / oil approx. 58 HRC  
 tempered 600° C approx. 53 HRC  
 1 layer on non-alloy steel approx. 45HRC

### Weld metal analysis in %

C	Si	Mn	Cr	Mo	V	W	Fe
0,35	1,0	0,4	5,0	1,5	0,3	1,3	balance

### Welding instruction

Clean welding area to metallic bright. Cracks in the base material have to be gouged out completely. Pre-heating temperature of 400° C on tools should be maintained. Stress relief, if necessary, at 550° C. Slow cooling.

### Welding procedures and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175					Availability	
		I 1	M 12	M 13	M 21	C 1	Spools EN ISO 544	Rods EN ISO 544
1,2 *	DC (+)		x	x	x	x	x	
1,6 *	DC (+)		x	x	x	x	x	
1,6 *	DC (-)	x						x
2,4 *	DC (-)	x						x
3,2 *	DC (-)	x						x

\* available on request

