UTP A CELSIT 706 V

CoCrW alloyed rod for TIG and gas welding

Standards :

DIN 8555	:	G/WSG 20-G0-40-CSTZ
EN 14700	:	R Z CO2
AWS A5.13	:	R CoCr-A

Application field

UTP A CELSIT 706 V is suitable for high grade hardfacing of parts subject to a combination of erosion, corrosion, cavitation, pressure, impact, abrasion and high heat up to 900° C, such as tight surfaces of fittings, valve seats and cones for combustion engines, gliding surfaces metal to metal, highly stressed hot working tools without thermal shock, milling, mixing and drilling tools.

Properties of the weld metal

Excellent gliding characteristics, very good polishability, high toughness, non-magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of the pure weld deposit:	40 - 42 HRC
Hardness at 600° C	approx. 33 HRC

Rod analysis in %

C	Cr	W	Co
1,2	27,0	4,5	balance

Welding instruction

Clean welding area, preheating temperature 450 - 600° C, very slow cooling.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175	Availability
			Rods
		I 1	L (mm)
3,2	DC (-)	x	1000
4,0	DC (-)	x	1000
5,0	DC (-)	x	1000

Approvals

KTA (No. 08115)

Adjust acetylene excess (reduced flame) in oxyacetylene welding.