

UTP A CELSIT 712 SN

Standards :

DIN 8555 : G/WSG 20-G0-50-CSTZ
 EN 14700 : R Co3
 AWSA5.13 : ~ R CoCr-B

CoCrW-alloyed welding wire for TIG- and gas welding

Application field

UTP A CELSIT 712 SN is suitable for highly wear resistant hardfacing of parts subject to a combination of abrasion, erosion, cavitation, corrosion, pressure and high heat up to 900° C, such as running, sealing and gliding faces of fittings and pumps, valve seats and cones for combustion engines, tools for the wood, paper and plastic industry, gliding surfaces metal to metal, milling, mixing and drilling tools, heavy-duty hot working tools without thermal shock.

Properties of the weld metal

Excellent gliding characteristics, good polishability, slightly magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of the pure weld deposit: 48 - 50 HRC
 Hardness at 600° C approx. 40 HRC

Rod analysis in %

C	Cr	W	Co
1,8	29,0	8,5	balance

Welding instruction

Clean welding area, preheating temperature 500 – 600° C, very slow cooling.

Welding procedure and availability

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

Adjust acetylene excess (reduced flame) in oxyacetylene welding.

