

## Classifications

EN 14700	DIN 8555	Material-No.
SZ Fe 1	MSG 1-GZ-250	1.8401

## Characteristics and field of use

UTP A DUR 250 is used for MAG buildups on structural parts subject to rolling wear and where a good machinability is required, such as rails and rail crossings, crane wheels, rollers, couplings, shafts and gear parts.

UTP A DUR 250 has a very good resistance against compression and rolling strain. The weld metal is easily machinable.

Hardness of the pure weld deposit : approx. 250 HB

## Typical analysis in %

C	Si	Mn	Cr	Ti	Fe
0.3	0.5	1.0	1.0	0.2	Balance

## Welding instruction

Machine welding area has to be metallic bright. Massive parts have to be preheated to 300 °C.

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

\*available on request

