UTP A DUR 600

solid wire

Classifications		
EN 14700	DIN 8555	Material-No.
S Fe 8	MSG 6-GZ-60-S	1.4718

Characteristics and field of use

UTP A DUR 600 is universally applicable for MAG buildups on structural parts subject to high impact and medium abrasion. Main applications are found in quarries, crushing plants, mines, steel works, cement works as well as cutting tools and dies in the car industry. Despite the high hardness, the deposit is very tough, crack resistant and has an excellent cutting behaviour.

Despite the high hardness, the weld deposit of UTP A DUR 600 is tough, crack resistant and has a good cutting capacity. Machining by grinding possible.

Hardness of the pure weld deposit

untreated	54 – 60 HRC
soft annealed 800° C	approx. 250 HB
hardened 1000° C/oil	approx. 62 HRC
1 layer on non-alloyed steel	approx. 53 HRC

Typical analysis in %

C	Si	Mn	Cr	Fe
0.5	3.0	0.5	9.5	balance

Welding instruction

Grind the welding area to metallic bright. Generally, only tool steels have to be preheated to 450 °C.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)			
0.8	DC (+)	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