

Standards :

DIN 8555 : E 20-UM-55-CSTZ
 EN 14700 : E Co3
 AWS A5.13 : ~ E CoCr-C

UTP CELSIT 701

Rutile coated stick electrode on Cobalt base, core wire alloyed

Application field

UTP CELSIT 701 is suited for highly wear resistant hardfacing on parts subject to severe abrasion in combination with corrosion and high temperatures up to 900° C, such as working parts in the chemical industry, running and sealing faces on fittings, valve seats and cones for combustion engines, cutting and crushing tools, hot working tools exposed to severe stresses without thermal shock, milling, mixing and drilling tools. Excellent gliding characteristics, good polishability, slightly magnetic.

Properties of the weld metal

Machining by grinding or with tungsten carbide cutting tools.

Welding properties

UTP CELSIT 701 has excellent welding properties, a homogeneous, finely rippled seam due to spray arc and very easy slag removal.

Hardness of the pure weld metal 54 - 56 HRC
 Hardness at 600° C approx. 42 HRC
 Hardness at 800° C approx. 34 HRC

Weld metal analysis in %

C	Cr	W	Co
2,3	32,0	13,0	balance

Welding instruction

Clean welding area, preheating temperature 500 – 600° C, very slow cooling. Hold stick electrode vertically with a short arc and lowest possible amperage. Re-dry stick electrodes that have become damp for 2h/300° C.

Current type DC (+) / AC

Welding positions


Availability / Current adjustment

Stick electrodes	Ø mm x L	3,2 x 300*	4,0 x 350*	5,0 x 400*
Amperage	A	70 – 110	90 – 130	110 – 150

* available on request

