

UTP CELSIT 706

Standards :

DIN 8555	: E 20-UM-40-CSTZ
EN 14700	: E Z Co2
AWSA5.13	: E CoCr-A

Rutile coated stick electrode on Cobalt base, core wire alloyed

Application field

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

Properties of the weld metal

Excellent gliding characteristics, easy polishability, good toughness, nonmagnetic. Machining by grinding or with tungsten carbide cutting tools.

Welding properties

UTP CELSIT 706 has excellent welding properties and a homogenous, finely rippled seam due to spray arc. Very easy slag removal.

Hardness of the pure weld deposit	40 - 42 HRC
Hardness at 500°C	approx. 130 HRC
Hardness at 700°C	approx. 160 HV

Weld metal analysis in %

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

Welding instruction

Clean welding area, preheating temperature 450 – 600° C, very slow cooling. Hold stick electrode vertically and with a short arc and lowest possible amperage. Re-dry stick electrodes that have become damp for 2 h / 300°C.

Current type DC (+) / AC

Welding positions



Availability / Current adjustment

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

* available on request

