

UTP CELSIT 712

Standards :

DIN 8555	:	E 20-UM-50-CSTZ
EN 14700	:	E Co3
AWSA5.13	:	~ E CoCr-B

Rutile coated stick electrode on Cobalt base, core wire alloyed

Application field

UTP CELSIT 712 is used for highly wear resistant hardfacing on parts subject to a combination of abrasion, erosion, cavitation, corrosion, pressure and high temperatures up to 900° C, such as running, sealing and gliding faces on fittings and pumps, tools for wood, paper, plastic, shredding tools, highly stressed hot working tools without thermal shock.

Properties of the weld metal

Machining by grinding or with tungsten carbide cutting tools.

Welding properties

UTP CELSIT 712 has excellent welding properties and a homogeneous, finely rippled seam due to spray arc. Very easy slag removal.

Hardness of the pure weld deposit	48 - 50 HRC
Hardness at 500° C	approx. 40 HRC
Hardness at 700° C	approx. 33 HRC

Weld metal analysis in %

C	Cr	W	Co
1,6	29,0	8,5	balance

Welding instruction

Clean welding area, preheating temperature 500 - 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

