

Standards :

DIN 8555 : E 20-UM-300-CKTZ
 EN 14700 : E CoI

UTP CELSIT 72I

**Rutile coated stick electrode on Cobalt base,
 core wire alloyed**

Application field

UTP CELSIT 72I is used for crack resistant hardfacing on parts subject to a combination of impact, pressure, abrasion, corrosion and high temperatures up to 900° C, such as running and sealing faces on gas, water, steam and acid fittings and pumps, valve seats and cones for combustion engines, working parts in gas and power plants, hot working tools with changing thermal load.

Properties of the weld metal

Excellent gliding characteristics, good polishability and toughness, highly workhardening, nonmagnetic, machinable with cutting tools.

Welding properties

UTP CELSIT 72I has excellent welding properties and a homogenous, finely rippled seam due to spray arc. Very easy slag removal.

Hardness of the pure weld metal 30 - 32 HRC
 workhardened approx. 45 HRC
 Hardness at 600° C approx. 240 HB

Weld metal analysis in %

C	Cr	Mo	Ni	Co
0,3	31,0	5,0	3,5	balance

Welding instruction

Clean welding area, preheating temperature 150 - 400° C, depending on the size of the workpiece and the base material. Slow cooling. Hold stick electrode vertically and 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 adjustments

Stick electrodes	Ø mm x L	3,2 x 350	4,0 x 350
Amperage	A	80 - 120	110 - 140

* available on request

