

Standards :

DIN 8555 : E I-UM-250
 EN 14700 : E FeI

UTP DUR 250

**Basic coated welding stick electrode
 for tough, easily machinable buildups
 against rolling wear**

Application field

UTP DUR 250 is used for surfacing on parts, where a tough and easily machinable deposit is required, such as rails, gear wheels, shafts and other parts on farming and building machineries. Also suitable as cushion and filler layer on non-alloyed and low-alloyed steels and cast steels.

Hardness of the pure weld deposit approx. 270 HB
 I layer on steel with C = 0,5 % approx. 320 HB

Properties of the weld metal

UTP DUR 250 has a very good resistance against compression and rolling strain. The weld metal is easily machinable.

Approximate weld metal analysis in %

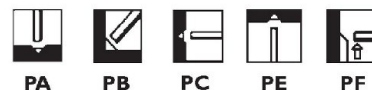
C	Si	Mn	Cr	Fe
0,15	1,1	1,2	0,8	balance

Welding instructions

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher-carbon steel qualities to 150 - 300° C. Re-dry stick electrodes that have got damp for 2h/300° C.

Current type DC (+) / AC

Welding positions


Availability / Current adjustment

Stick electrodes	Ø mm x L	3,2 x 450	4,0 x 450	5,0 x 450	6,0 x 450*
Amperage	A	100 – 140	140 – 180	180 – 230	230 - 300

* available on request

