

Standards :

DIN 8555 : E I-UM-350
 EN 14700 : E FeI

UTP DUR 350

**Basic coated welding stick electrode
 for crack and wear resistant surfacings**

Application field

UTP DUR 350 is particularly suited for wear resistant surfacings on Mn-Cr-V alloyed parts, such as frogs, track rollers, chain support rolls, sprocket wheels, guide rolls etc.

The deposit is still machinable with tungstene carbide tools.

Properties of the weld metal

UTP DUR 350 has a very good resistance against compression and rolling strain in combination with slight abrasion. The weld metal is machinable with tungstene carbide tools.

Hardness of the pure weld deposit approx. 370 HB

I layer on steel with C = 0,5 % approx. 420 HB

Approximate weld metal analysis in %

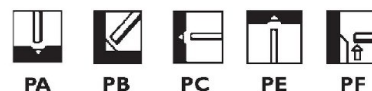
C	Si	Mn	Cr	Fe
0,2	1,2	1,4	1,8	balance

Welding instruction

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher-tensile steels to 250 - 350° C. Stick electrodes that have got damp should be re-dried for 2 h / 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
Amperage	A	100 – 140	140 – 180	180 – 230

Approvals

DB (No. 20.138.06)

