

Standards :

DIN 8555 : E 6-UM-60
 EN 14700 : E Fe8

UTP DUR 600

Basic coated hardfacing stick electrode resisting impact and abrasion

Application field

UTP DUR 600 is universally applicable for cladding on parts of steel, cast steel and high Mn-steel, subject simultaneously to abrasion, impact and compression. Typical application fields are the earth moving and stone treatment industry, e.g. excavator teeth, bucket knives, crusher jaws and cones, mill hammers etc., but also for cutting edges on cold cutting tools.

Hardness of the pure weld deposit 56 - 58 HRC
 After soft-annealing 780 - 820° C / oven approx. 25 HRC
 After hardening 1000 - 1050° C / oil approx. 60 HRC
 1 layer on high Mn-steel approx. 22 HRC
 2 layers on high Mn-steel approx. 40 HRC

Welding properties and special properties of the weld metal

UTP DUR 600 has excellent welding properties due to a quiet arc, an even flow and a good weld build-up, easy slag removal. Machining of the weld metal possible by grinding.

Weld metal analysis in %

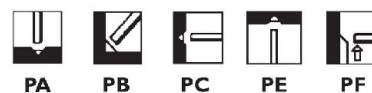
C	Si	Mn	Cr	Fe
0,5	2,3	0,4	9,0	balance

Welding instruction

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and high-tensile steels to 200 - 300° C. On high Mn-steel, cold welding (max. 250° C) is recommended, if necessary, intermediate cooling. On parts tending to hardening cracks, a cushion layer with UTP 630 is welded. UTP 630 should also be used for welding cracks under hardfacings. If more than 3 - 4 layers are needed, apply the softer stick electrodes UTP DUR 250 or UTP DUR 300 for build-up. 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	2,5 x 300	3,2 x 350	4,0 x 450	5,0 x 450
Amperage	A	80 - 100	100 - 140	140 - 180	180 - 210

Approvals

DB (No. 20.138.07)

