

Standards :

DIN 8555 : E 10-UM-60-GRZ
 EN 14700 : E Fe14
 AWS A5.13 : ~ E FeCr-A 1

UTP LEDURIT 61

**Rutile-basic coated hardfacing stick electrode for high abrasion and medium impact
 Recovery 160 %**

Application field

UTP LEDURIT 61 is suited for highly wear resistant claddings on parts subject to strong grinding abrasion combined with medium impact, such as conveyor screws, scraper blades, digging teeth, mixer wings, sand pumps. Also as a final layer on crusher jaws.

Welding properties

UTP LEDURIT 61 has excellent welding characteristics and a very easy slag removal. The homogeneous and finely rippled seam surface does, for most applications, not require any finish-ing by grinding.

Hardness of the pure weld deposit approx. 60 HRC

1 layer on steel with C = 0,15 % approx. 55 HRC

1 layer on high Mn-steel approx. 52 HRC

Weld metal analysis in %

C	Si	Cr	Fe
3,5	1,0	35,0	balance

Welding instruction

Hold stick electrode as vertically as possible, keep a short arc. Preheating is in general not necessary. On multipass-applications a cushion layer with UTP 630 is recommended in order to prevent hardening cracks in the weld deposit. 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 350	3,2 x 350	4,0 x 450	5,0 x 450
Amperage	A	80 – 100	90 – 130	130 – 180	140 – 190

