

UTP LEDURIT 65

Standards :

DIN 8555 : E 10-UM-65-GRZ
EN 14700 : E Fe16

**High-efficiency stick electrode without slag
resisting extreme abrasion at elevated tem-
peratures**

Application field

UTP LEDURIT 65 is suited for highly abrasion resistant claddings on parts subject to extreme sliding mineral abrasion, also at elevated temperatures up to 500° C. The extremely high abrasion resistance is reached by the very high content of special carbides (Mo, V, W, Nb). Main application fields are surfacings on earth moving equipment, working parts in the cement and brick industry as well as in steel mills for radial breakers and revolving-bar screens of sintering plants.

Welding properties

UTP LEDURIT 65 has an even droplet transfer in the spray arc. The smooth welding bead is without slag covering. In general there is no need for any finishing by grinding.

Hardness of the pure weld deposit approx. 65 HRC
I layer on steel with C = 0,15 % approx. 58 HRC
I layer on high Mn-steel approx. 55 HRC

Weld metal analysis in %

C	Cr	Mo	Nb	V	W	Fe
4,5	23,5	6,5	5,5	1,5	2,2	balance

Welding instruction

Hold stick electrode as vertically as possible, keep a short arc. Reduce dilution with the base metal by weaving. For multipass applications a cushion layer with UTP 630 is recommended. Re-dry stick electrodes that have got damp for 2h/300° C.

Current type DC (+) / AC

Welding positions



PA

Availability / Current adjustment

Stick electrodes	Ø mm x L	3,2 x 350	4,0 x 450	5,0 x 450
Amperage	A	110 – 150	140 – 200	190 – 250

