UTP 673

rutile coated stick electrode

Classifications	
DIN 8555	EN 14700
E 3-UM-60-ST	E Z Fe3

Characteristics and field of use

UTP 673 is used for wear resistant buildups on cold and hot working tools, particularly for cutting-edges on hot cutting tools, hot-shear blades, trimming tools and cold cutting knives. The production of new cutting tools by welding on non-alloy or low-alloy base materials is also possible.

UTP 673 has excellent welding properties, a homogeneous, finely rippled bead appearance due to the spray arc and very easy slag removal. This stick electrode is weldable with very low amperage settings (advantage for edge buildup).

Heat resistant up to 550° C Hardness of the pure weld metal: approx. 58 HRC

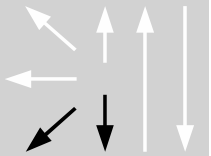
Typical analysis in %

C	Si	Mn	Cr	Mo	V	W	Fe
0,3	0,8	0,4	5,0	1,5	0,3	1,3	balance

Welding instruction

Preheat high-alloy tool steels to 400 – 450° C and maintain this temperature during the whole welding process. Hold stick electrode vertically with a short arc and lowest possible amperage setting. Machining only by grinding. Redry stick electrodes that have got damp for 2h/300° C.

Welding positions



Current type DC (–) / DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2,0 x 300*	2,5 x 300	3,2 x 350	4,0 x 400
Amperage [A]	30 – 50	50 – 70	90 – 120	130 – 160

*available on request