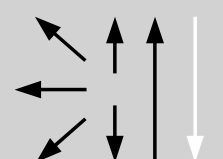


Classifications				
DIN 8555		EN 14700		
E 1-UM-250		E Fe1		
Characteristics and field of use				
<p>UTP DUR 250 is used for surfacing on parts, where a tough and easily machinable deposit is required, such as rails, gear wheels, shafts and other parts on farming and building machineries. Also suitable as cushion and filler layer on non-alloyed and low-alloyed steels and cast steels.</p> <p>Hardness of the pure weld deposit approx. 270 HB 1 layer on steel with C = 0,5 % approx. 320 HB</p> <p>UTP DUR 250 has a very good resistance against compression and rolling strain. The weld metal is easily machinable.</p>				
Typical analysis in %				
C	Si	Mn	Cr	Fe
0,15	1,1	1,2	0,8	balance
Welding instruction				
<p>Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher-carbon steel qualities to 150 – 300° C. Redry stick electrodes that have got damp for 2h/300° C.</p>				
Welding positions				
		Current type DC (+) / AC		
Recommended welding parameters				
Electrodes Ø x L [mm]	3,2 x 450	4,0 x 450	5,0 x 450	6,0 x 450*
Amperage [A]	100 – 140	140 – 180	180 – 230	230 – 300
* available on request				