UTP 7008

rutile basic coated high efficiency electrode

Classifications	
DIN 8555	EN 14700
E 23-UM-250-CKTZ	E Z Ni2

Characteristics and field of use

UTP 7008 is particularly suited for wear resisting cladding on hot working tools subject to thermal load, such as forging saddles, forging jaws, forging dies, hot piercing plugs, hot cutting knives, hot trimming tools and hot press rams.

UTP 7008 has excellent welding properties, a homogeneous, finely rippled bead appearance due to the spray arc, very easy slag removal. The weld deposit is highly corrosion resistant, scale resistant and workhardening. Machinable with cutting tools.

Hardness of the pure weld deposit :	approx. 260 HB
workhardened	approx. 500 HB

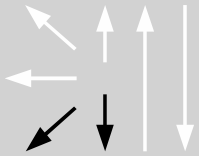
Typical analysis in %

C	Si	Mn	Cr	Mo	Ni	V	W	Fe
0,04	0,5	1,3	16,0	16,0	balance	1,0	7,0	6,0

Welding instruction

Clean welding area. Preheat tools to 350 – 400° C, temperature should be maintained during the welding process. Slow cooling in oven. Hold stick electrode as vertically as possible and with a short arc. Select lowest possible amperage, in order to reduce dilution with the base metal. Redry stick electrodes that have got damp for 2 h / 300° C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 350	3,2 x 350	4,0 x 350
Amperage [A]	60 – 90	80 – 120	110 – 150