UTP 73 G 2

basic coated stick electrode

Classifications	
DIN 8555	EN 14700
E 3-UM-55-ST	E Fe8

Characteristics and field of use

UTP 73 G 2 is, due to its high hardness, toughness and heat resistance ideally suited for buildups on parts subject to severe friction, compression and moderate impact loads at elevated temperatures, such as back centers, gripping pliers, gliding and guiding surfaces, hot and cold punching tools, valves, slides, hot-shear blades, extrusion press pristons, forging tools, stripping columns, trimming tools, roll mandrils, punching tools for sheet metals. UTP 73 G 2 is used to good advantage for the production of new cold and hot working tools. In such cases cladding is made on base material with an accordingly high tensile strength.

The stick electrode has excellent welding properties, a stable and regular flow, good bead appearance and very easy slag removal. Heat resistant up to 550° C

Hardness of the pure weld metal: 55 - 58 HRC

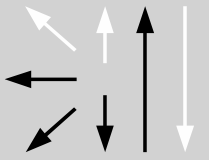
Typical analysis in %

C	Si	Mn	Cr	Mo	Fe
0,2	0,5	1,3	7,0	2,5	balance

Welding instruction

Preheat the workpiece to 400° C. Hold stick electrode as vertically as possible and with a short arc. Allow the workpiece to cool down slowly. Finishing by grinding. Redry stick electrodes that have got damp for 2h/300° C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 300	3,2 x 350	4,0 x 400	5,0 x 400
Amperage [A]	60 – 90	80 – 110	100 – 140	130 – 170