

Classifications

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| DIN 8555 | EN 14700 |
| E 3-UM-45-T | E Fe3 |

Characteristics and field of use

UTP 73 G 3 is, due to its high strength, toughness and heat resistance ideally suited for buildups on parts subject to friction, compression and impact at elevated temperatures, such as hot shears blades, gate shear, forging saddles, hammers, forging dies, Al-die cast moulds. UTP 73 G 3 is also used to good advantage for the production of new cold and hot working tools with low-alloy base materials.

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: approx. 45 – 50 HRC

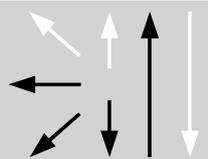
Typical analysis in %

| C | Si | Mn | Cr | Mo | Fe |
|-----|-----|-----|-----|-----|---------|
| 0,2 | 0,5 | 0,6 | 5,0 | 4,0 | balance |

Welding instruction

Preheat the workpiece to 400° C. Hold stick electrode as vertically as possible and with a short arc. Take care of a slow cooling of the workpiece. Finishing by grinding or hard metal alloys. 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 – 100 | 100 – 140 | 130 – 170 |

*available on request