

Classifications

EN 14700	DIN 8555	Material-No.
S Z Fe5	MSG 3-GZ-350-T	1.6356

Characteristics and field of use

UTP A 702 is used for repair, preventive maintenance and production of highly stressed cold and hot working tools, such as punching dies, cold and hot cutting knives, Al-die cast moulds, cold forging dies, drawing-, stamping- and chamfering tools. The weld deposit is, in as-welded condition, machinable, and the subsequent artificial aging optimises the resistance to hot wear and alternating temperatures.

The weld deposit of UTP A 702 has high strength and good toughness.

Hardness of the pure weld deposit:

untreated 32 – 35 HRC

hot-aged 3 – 4 h / 480 °C : 50 – 54 HRC

Typical analysis in %

C	Mo	Ni	Co	Ti	Al	Fe
0.02	4.0	18.0	12.0	1.6	0.1	balance

Welding instruction

Machine welding area has to be metallic bright. Preheat massive pieces to 100 – 150 °C, on low-alloyed base metal apply min. 3 – 4 layer. Weld with lowest possible heat input.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)			
1.0*	DC (+)	M 12	M 13	M 20	M 21
1.2	DC (+)	M 12	M 13	M 20	M 21

*available on request