UTP DUR 600

Standard: DIN 8555 : E 6-UM-60

Basic coated hardfacing electrode resisting impact and abrasion

Application field

UTP DUR 600 is universally applicable for cladding on parts of steel, cast steel and high Mn-steel, subject simultaneously to abrasion, impact and compression. Typical application fields are the earth moving and stone treatment industry, e.g. excavator teeth, bucker knives, crusher jaws and cones, mill hammers etc., but also for cutting edges on cold cutting tools. The deposit is machinable by grinding only.

Hardness of pure weld deposit	56 – 58 HCR
After soft-annealing 780 -820°C / oven	approx. 25 HRC
After hardening 1000 – 1050°C / oil	approx. 60 HRC
1 layer on high Mn-steel	approx. 22 HRC
2 layers on high Mn-steel	approx. 40 HRC

Weld metal analysis in %

C	Si	Mn	Cr
0,5	2,3	0,4	9

Welding instruction

Hold electrode as vertically as possible and with a short arc. Preheat heavy parts and high-tensile steels to 200- 300°C. On high Mn-steel, cold welding (max. 250°C) is recommended, if necessary, intermediate cooling. On parts tending to hardening cracks, a cushion layer with UTP 630 is welded. UTP 630 should also be used for welding cracks under hardfacings. If more than 3 – 4 layers are needed, apply the softer electrodes UTP DUR 250 or UTP DUR 300 for build-up. Re-dry electrodes that have got damp for 2h / 300°C.

Current type: DC (+) / AC

Welding positions :

PA PB PF PC PE

Current adjustment:

Electrode	∅ mm × L	2,5 x 300*	3,2 × 450	4,0 × 450	5,0 × 450
Amperage	A	80 - 100	100 -140	140 - 180	180 - 210

**available on request*

Additional information: Weld deposit can be nitrated and chrom-plated.

Approvals: DB, ÖBB

Bad Krozingen, 11/06, Rev. 0, Hn-as