



# 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, bucket 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

After soft-annealing 780 -820°C / oven

After hardening 1000 – 1050°C / oil

1 layer on high Mn-steel

2 layers on high Mn-steel

56 – 58 HCR

approx. 25 HRC

approx. 60 HRC

approx. 22 HRC

approx. 40 HRC

### Weld metal analysis in %

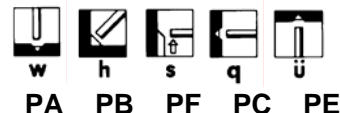
C	Si	Mn	Cr
0,5	2,3	0,4	9

### 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 :**



### Current adjustment:

Electrode	Ø mm x L	2,5 x 300*	3,2 x 450	4,0 x 450	5,0 x 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

The data which are given here are based upon careful investigation and intensive research. However, we cannot assume any liability for the use of our products out of the above-mentioned field of application.

We recommend the user to test – on his own responsibility – our products with regard to their special application.