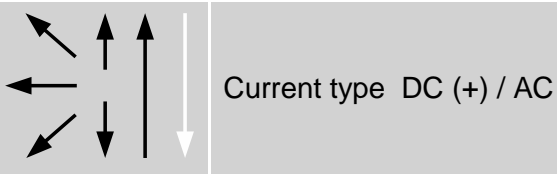


Classifications				
DIN 8555		EN 14700		
E6-UM-60		E Fe8		
Characteristics and field of use				
<ul style="list-style-type: none"> <li>➤ Martensitic microstructure with good resistance to abrasion, impact and compression.</li> <li>➤ Universally applicable for cladding parts of steels, cast steels and high Mn-steel, subjected a simultaneously to abrasion, impact and compression. Typical application fields are the earth moving and stone treatment industry, e.g. excavator bucket teeth, crusher jaws and cones, mill hammers, rotors, etc.</li> <li>➤ Good weldability and easy slag removal, machining of the weld metal possible by grinding only.</li> </ul>				
Hardness of the pure weld deposit		55 HRC		
1 layer on high Mn-steel		22 HRC		
2 layer on high Mn-steel		40 HRC		
Typical analysis of all weld metal (Wt.-%)				
C	Si	Mn	Cr	Fe
0.50	2.50	0.40	9.50	Balance
Welding instruction				
<p>Hold stick as vertically as possible and with short arc. Preheating recommended for heavy parts and higher tensile steels to 200 – 300°C. On high Mn-Steel, cold welding (interpass temperature max. 250°C) is recommended. If necessary, intermediate cooling. If more than 3 – 4 layers are needed, apply the softer stick electrode UTP S DUR 250 /UTP DUR S 350 / UTP S 63 / UTP S BMC for build-up.</p>				
Welding positions				
				
Approvals				
-				
Size, Packing and Recommended welding parameters				
Size mm	Kg / Pack	Kg / Box	Amperage (A)	
2.50 x 350	4.60	18.40	80 – 100	
3.25 x 350	5.00	20.00	100 – 140	
4.00 x 450	6.20	24.80	140 – 180	
5.00 x 450	6.20	24.80	180 – 210	