

Classifications

TIG rod

EN 14700	DIN 8555	Material-No.
S Fe8	WSG 3-60-T	1.2606

Characteristics and field of use

UTP A 673 is used for the repair and production of hot working tools, such as die cast moulds, forging dies, hot cutting knives, hot-shear blades, axial rolls, roll mandrills, upset plates as well as for the production of working surfaces on non- or low-alloyed base materials.

Machining is possible with tungsten carbide tools.

Hardness of the pure weld deposit:

untreated	53 – 58 HRC
soft-annealed 820 °C	approx. 230 HB
hardened 1050 °C / oil	approx. 53 – 58 HRC
tempered 600 °C	approx. 53 HRC
1 layer on non-alloyed steel	approx. 45 HRC

Typical analysis of rod and wire in %

C	Si	Mn	Cr	Mo	V	W	Fe
0.35	1.0	0.4	5.0	1.5	0.3	1.3	balance

Welding instructions

Clean welding area to metallic bright. Cracks in the base material have to be completely gouged out. Pre-heating temperature of 400 °C should be maintained on tools. Stress relief, if necessary, at 550 °C. Slow cooling-down.

Form of delivery and recommended welding parameters

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
1.6 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1
3.2 x 1000	DC (-)	I 1