UTP A Celsit 721

Tool steels

Classifications		TIG rod
EN 14700	DIN 8555	AWS A 5.21
R Z Co1	G/WSG 20-G0-300-CKTZ	ER CoCr-E

Characteristics and field of use

UTP A CELSIT 721 is a CoCrMo-alloyed rod for TIG and gas welding and especially suitable for hardfacing of parts subject to a combination of pressure, impact, abrasion, corrosion and high temperatures up to 900 °C, such as running and sealing faces of gas-, water-, steam- and acid fittings and pumps; valve seats and cones for combustion engines; working parts on turbines and power plants; hot-working tools with frequent changes of high thermal load.

Properties of the weld metal
Excellent gliding characteristics, very good polishability, high toughness, non-magnetic.

Hardness of the pure weld deposit: 30 – 32 HRC
Work-hardened: approx. 45 HRC
Hardness at 600 °C: approx. 240 HB

Typical analysis of rod and wire in %

C	Cr	Mo	Ni	Co
0.25	28.0	5.0	2.8	balance

Welding instructions

Clean welding area, preheat to 150 – 400 °C, depending on size of the workpiece and base material. Slow cooling.

Form of delivery and recommended welding parameters

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

Adjust acetylene excess (reducing flame) in oxyacetylene welding.