

UTP A DUR 600

Tool steels

Classifications

TIG rod

EN 14700

DIN 8555

Material-No.

S Fe8

WSG 6-GZ-60-S

1.4718

Characteristics and field of use

UTP A DUR 600 is a TIG rod for hardfacing components which are subject to high impact and medium abrasion. Main applications are quarries, crushing plants, mines, steel works and cement works, as well as cutting tools and dies in the automotive industry.

Properties of the weld metal

Despite the high hardness, the weld deposit of UTP A DUR 600 is tough, crack-resistant and has a good cutting capacity. Machining is possible by grinding.

Hardness of the pure weld deposit

As welded: 54 – 60 HRC

Soft-annealed 800 °C: approx. 250 HB

Hardened 1000 °C / oil: approx. 62 HRC

1 layer on non-alloyed steel: approx. 53 HRC

Typical analysis of rod and wire in %

| C | Si | Mn | Cr | Fe |
|-----|-----|-----|-----|---------|
| 0.5 | 3.0 | 0.5 | 9.5 | balance |

Welding instructions

Grind the welding area to a bright metallic finish.

Tool steels should be preheated to 250 – 450 °C, depending on base metal, application and requirements.

Form of delivery and recommended welding parameters

| Rod diameter x length [mm] | Current type | Shielding gas (EN ISO 14175) |
|----------------------------|--------------|------------------------------|
| 1.0 x 1000 mm* | DC (-) | I 1 |
| 1.2 x 1000 mm* | DC (-) | I 1 |
| 1.6 x 1000 mm | DC (-) | I 1 |
| 2.0 x 1000 mm | DC (-) | I 1 |
| 2.4 x 1000 mm | DC (-) | I 1 |
| 3.0 x 1000 mm | DC (-) | I 1 |

* available on request

GTAW – TIG rods

140