

Classifications

EN 14700	DIN 8555
S Fe8	W3-GZ-55-ST

Characteristics and typical fields of application

UTP A 73 G 2 is used for highly wear resistant build-ups on machine parts and tools, subject to heavy abrasion and compression combined with moderate impact at elevated temperatures, such as forging tools, roll mandrils, hot trimming knives, mangle and axial rolls as well as for the production of high-quality working surfaces by cladding non- or low-alloy base material.

Machinable by grinding or with tungsten carbide tools.

Typical analysis

	C	Si	Mn	Cr	Mo	Ti	Fe
wt.-%	0.35	0.3	1.2	7.0	2.0	0.3	bal.

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Hardness
unbehandelt / as welded	53-58
weichgeglüht / soft-annealed 820°C	200
gehärtet / hardened 1050°C / Öl / Oil	58
angelassen / annealed 600°C	53
first layer / Layer unleg. Stahl / unal. steel	45
u untreated, as-welded	

Operating data

Polarity	DC -	Dimension mm
Shielding gas (EN ISO 14175)	I1	1.2 × 1000
		1.6 × 1000
		2.0 × 1000
		2.4 × 1000
		3.2 × 1000
		4.0 × 1000

Clean welding area to metallic bright. Cracks in the base material have to be gouged out completely. Preheating temperature of 400°C on tools should be maintained. Stress relief/ annealing is recommended at 550°C.

Approvals

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