UTP A 73 G 4

TIG rod, wear protection

Classifications

EN 14700	DIN 8555
S Z Fe3	W3-GZ-40-T

Characteristics and typical fields of application

UTP A 73 G 4 is, due to its excellent hot wear resistance and toughness, used for build-ups on hot working tools and structural parts subject to impact, compression and abrasion at elevated temperatures, such as forging dies, die cast moulds, plastic moulds, guides, recipients, continuous casting rolls. Hot wear resistant claddings can be made on non-alloy or low-alloy base materials, such as e. g. boiler tubes in coal burning power stations.
The deposit is machinable with cutting tools.

Typical analysis

	C	Si	Mn	Cr	Mo	Fe
wt.-%	0.1	0.4	0.6	6.5	3.3	bal.

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

Condition	Hardness	
unbehandelt / as welded	38-42	
weichgeglüht / soft-annealed 800°C		230
gehärtet / hardened 1030°C / Öl / Oil	48	
angelassen / annealed 550°C	42	
first layer / Layer unleg. Stahl / unal. steel	30	

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

Machine welding area to metallic bright. Cracks in the base material have to be gouged out completely. Preheating temperature of 400ºC on tools should be maintained. Stress relief/annealing is recommended at 550ºC. Preheating on non- and low-alloy materials is generally not required.

Approvals

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All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.