

UTOPWELD 45

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:		APPROVALS:		APPLICATION:	
DIN 8555 : E3-UM-50-T			Hardfacing		and repairing
 A basic electrode for the repair of hot working tools. Recommended for the regeneration of hard edges or tool surfaces of low-alloy steels with increased strength. 					
Recommendations:					
 Depending on the base material, it is recommended to heat the material and maintain the interpass temperature between 300°C and 450°C. After surfacing, slow cooling should take place. Cures between 1060°C and 1120°C (oil, hot bath, compressed air) Tempering: approx. 3h / temperature depending on the desired hardness Soft annealing: 2 - 4 h at 800°C to 840°C / carry out slow cooling in the furnace 					
Application					
Punching dies, die ins	erts, cutting to	ools, shears for shee	et metal, drawing	tools, forging	dies.
Base material					
1.2365 32CrMo 1.2567 30WCrV 1.2581 X30WC		0V12-283 V17-2 rrV9-3	1.2713 1.2714		5NiCrMoV6 5NiCrMoV7
Typical chemical composition %					
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