

## UTOPWELD 55

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 14700-A : E Fe4 DIN 8555 : E 6-UM-60-PTS	UDT	Hardfacing and repairing

- Basic electrode with additions of Mo, Cr and V.
- High resistance to ductility, wear, impact.
- The weld metal is only machined mechanically by grinding and gouging after slight tempering.
- Recommended for surfacing of cold and hot working tools.

### Application

Die plates, dies and containers, presses for extrusion of metal pipes and rods; for the manufacture of shafts, screws, nuts, rivets and pins, casting dies, die inserts, knives of hot working shears and others.



### Base material

Tool steels

### Typical chemical composition %

<b>C</b>	<b>Cr</b>	<b>Mo</b>	<b>V</b>	<b>W</b>
0,50	5,00	5,00	0,60	+

### Typical mechanical properties

<b>Hardness</b>	55 - 60 HRC / The hardness of the overlay depends on the relevant welding conditions, the number of layers and the chemical composition of the base material. /
<b>Coating type</b>	basic
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Redrying</b>	400°C / 1 h

### Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	70-90	4,0	12,0	58
3,2	350 /	110-135	4,4	13,2	28
4,0	450 /	130-170	5,4	16,2	15
5,0	450 /	180-220	5,4	16,2	7

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