

UTOPWELD 55

Electrodes MMA [SMAW]

Hardfacing and repairing

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

C	Cr	Mo	V	W
0,50	5,00	5,00	0,60	+

Typical mechanical properties

Hardness	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. /
Coating type	basic
Welding current	
Welding positions	
Redrying	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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