

UTOPWELD 38

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe3 DIN 8555 : E 3-UM-40-PT	UDT	Hardfacing and repairing

- Basic electrode with additions of Mo, Cr and V.
- High resistance to tensile strength, abrasion, impact.
- The weld metal is easily machined.
- Deposited weld is resistant to metal-to-metal wear.
- Recommended for hardfacing hot and cold working tools and for filling cavities.
- For operation at high temperatures: > 900°C.

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 and others. Regeneration of teeth in gears.

Base material

Tool steels

Typical chemical composition %

C	Cr	Mo	V	W
0,13	5,00	4,00	0,20	+

Typical mechanical properties

Hardness	36 - 42 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
Additional description	Recommended preheating 300-500°C

Welding parameters and packing

Ø	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	57
3,2	350 /	110-135	4,4	13,2	28
4,0	450 /	130-170	5,4	16,2	14
5,0	450 /	180-220	5,5	16,5	6

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