

UTP 702

Standards :

DIN 8555 : E 3-UM-350-T
EN 14700 : E Fe5

Basic coated, age-hardenable martensitic stick electrode for wear resistant hardfacings on cold and hot working tools

Application field

Due to its high-grade structure, **UTP 702** is used for repair, preventive maintenance and production of highly stressed cold and hot working tools, such as punching tools, cold shears for thick materials, drawing -, stamping - and trimming tools, hot cutting tools, Al-die cast moulds, plastic moulds, cold forging tools. The weld deposit is, in as-welded condition, easily machinable and the subsequent age hardening optimises the resistance to wear and alternating temperatures.

Welding instruction

UTP 702 has excellent welding properties, a smooth and regular drop transfer, good bead appearance and easy slag removal.

Hardness of the pure weld metal:

untreated: 34 - 37 HRC
After age hardening 3 - 4 h / 480° C 50 - 54 HRC

Weld metal analysis in %

C	Si	Mn	Mo	Ni	Co	Ti	Fe
0,025	0,2	0,6	4,0	20,0	12,0	0,3	balance

Welding instruction

Clean welding area to metallic bright. Only massive tools should be preheated to 100 - 150° C. On low-alloy steels at least 3 - 4 layers should be applied. Keep heat input as low as possible.

Current type DC (+)

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 250	3,2 x 350	4,0 x 350
Amperage	A	70 - 90	100 - 120	120 - 140