

UTP 73 G 2

Standards :

DIN 8555 : E 3-UM-55-ST
EN 14700 : E Fe8

Basic coated stick electrode for wear resistant surfacings on hot and cold working steels

Application field

UTP 73 G 2 is, due to its high hardness, toughness and heat resistance ideally suited for buildups on parts subject to severe friction, compression and moderate impact loads at elevated temperatures, such as back centers, gripping pliers, gliding and guiding surfaces, hot and cold punching tools, valves, slides, hot-shear blades, extrusion press pistons, forging tools, stripping columns, trimming tools, roll mandrils, punching tools for sheet metals.

UTP 73 G 2 is used to good advantage for the production of new cold and hot working tools. In such cases cladding is made on base material with an accordingly high tensile strength.

Welding properties

The stick electrode has excellent welding properties, a stable and regular flow, good bead appearance and very easy slag removal. Heat resistant up to 550° C

Hardness of the pure weld metal : 55 - 58 HRC

Weld metal analysis in %

C	Si	Mn	Cr	Mo	Fe
0,35	0,5	1,3	7,0	2,5	balance

Welding instruction

Preheat the workpiece to 400° C. Hold stick electrode as vertically as possible and with a short arc. Allow the workpiece to cool down slowly. Finishing by grinding. Re-dry stick electrodes that have got damp for 2h/300° C.

Current type DC (+) / AC

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 300	3,2 x 350	4,0 x 400	5,0 x 400
Amperage	A	60 – 90	80 – 110	100 – 140	130 – 170