

UTP A 661

Standards :

Material-No. : 1.4115
 DIN 8555 : W/MSG 5-GZ-400-RZ
 EN 14700 : S Fe7

Wire for wear and corrosion resistant surfacings

Application field

UTP A 661 is used for wear resistant claddings on construction parts made of non-alloyed or low-alloyed steels and cast steels, hot working steels, high alloyed steels and cast steels, particularly for one-layer-welding. Special application fields are claddings on machine parts made of high tensile steel for hardening and tempering, hot working tools, continuous casting rolls and dummy blocks, membrane sides in coal burning power stations and parts resistant against high temperature up to 900° C.

Special properties of the weld deposit

The martensitic weld deposit is wear resistant also at elevated temperatures. It is resistant against water, seawater, steam and diluted organic acids. High thermal strength.

Hardness of the pure weld deposit

untreated : approx. 40 HRC
 one-layer-welding on C 45 : approx. 55 HRC

Weld metal analysis in %

C	Si	Mn	Cr	Mo	Fe
0,22	0,7	0,7	17,5	1,2	balance

Welding instruction

UTP A 661 Welding with MIG pulsed current provides a low-in-spatter deposit of perfect appearance. The preheating must be matched to the parent metal and the welding scope, generally between 150° C - 400° C. Slow cooling in still air or under a cover resp. in an oven. Tempering, if necessary.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175					Availability	
		I I	M I2	M I3	M 2I	C I	Spools	Rods
							EN ISO 544	EN ISO 544
1,0 *	DC (+)		x	x	x	x		
1,2	DC (+)		x	x	x	x		
1,6	DC (+)		x	x	x	x		
2,4	DC (-)	x					x	

* available on request

Approvals

TÜV (No. 06743)