

## UTP A 702

### Standards :

Material-No. : I.6356  
 DIN 8555 : W/MSG 3-GZ-350-T  
 EN 14700 : S Z Fe5

**High alloyed, age-hardenable wire for high wear resistant surfacings on cold and hot working tools**

### Application field

**UTP A 702** is used for repair, preventive maintenance and production of highly stressed cold and hot working tools, such as punching dies, cold and hot cutting knives, Al-die cast moulds, cold forging dies, drawing-, stamping- and chamfering tools. The weld deposit is, in as-welded condition, machinable, and the subsequent artificial aging optimises the resistance to hot wear and alternating temperatures.

### Properties of the weld metal

The weld deposit of **UTP A 702** has high strength and good toughness.

### Hardness of the pure weld deposit

untreated : 32 - 35 HRC  
 hot-aged 3 - 4 h / 480° C : 50 - 54 HRC

### Weld metal analysis in %

C	Mo	Ni	Co	Ti	Al	Fe
0,02	4,0	18,0	12,0	1,6	0,1	balance

### Welding instruction

Machine welding area to metallic bright. Preheat massive pieces to 100 - 150° C, on low-alloyed base metal apply min. 3 - 4 layer. Weld with lowest possible heat input.

### Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175					Availability	
		I 1	M 12	M 13	M 20	M 21	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	
2,0	DC (-)	x					x	
2,4	DC (-)	x					x	

\* available on request