

UTP A 73 G 2

Standards :

Material-No. : Special alloy
 DIN 8555 : W/MSG 3-GZ-55-ST
 EN 14700 : S Z Fe8

Copper coated wire for highly wear resistant build-ups on hot and cold working tools

Application field

UTP A 73 G 2 is used for highly wear resistant buildups on machine parts and tools, subject to heavy abrasion and compression combined with moderate impact at elevated temperatures, such as forging tools, roll mandrils, hot trimming knives, mangle and axial rolls as well as for the production of high-quality working surfaces by cladding non- or low-alloy base material.

Properties of the weld metal

Machinable by grinding or with tungstene carbide tools

Hardness of the pure weld deposit :

untreated	53 - 58 HRC
soft-annealed 820° C	approx. 20 HB
hardened 1050° C/oil	approx. 58 HRC
tempered 600° C	approx. 53 HRC
1 layer on non-alloyed steel	approx. 45 HRC

Weld metal analysis in %

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

Welding instruction

Clean welding area to metallic bright. Cracks in the base material have to be gouged out completely. Pre-heating temperature of 400° C on tools should be maintained. Stress relief, if necessary, at 550° C.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175					Availability	
		I I	M I 2	M I 3	M 2 I	C I	Spools	Rods
							EN ISO 544	EN ISO 544
0,8 *	DC (+)		x	x	x	x		
1,0	DC (+)		x	x	x	x		
1,2	DC (+)		x	x	x	x		
1,6	DC (+)		x	x	x	x		
1,6	DC (-)	x					x	
2,0	DC (-)	x					x	
2,4	DC (-)	x					x	
3,2	DC (-)	x					x	
4,0 *	DC (-)	x					x	

* available on request