

UTP A 7560

Standards :

DIN 8555 : G 21-GF-60 G
EN 14700 : T Fe 20

Tungsten-carbide tube rod against extreme mineral abrasion

Application field

The filled gas welding rod **UTP A 7560** is suitable for claddings on tools and machine parts subject to highest mineral wear, such as drill bits, roller bits, sets of drill-rods, excavator buckets, mixer blades. It is also suitable for highly stressed machine parts, which are used for the reprocessing of sand, cement, lime, clay, coal, slags.

Properties of the weld metal

UTP A 7560 is suited for extreme mineralic abrasion with medium impact strain.

Hardness

Carbide : approx. 2500 HV
Matrix : approx. 60 HRC

Weld metal analysis in %

W ₂ C	FeC
60,0	40,0

Welding instruction

Clean welding area to metallic bright. Preheating temperature 300 - 500° C, depending on the size of the workpiece. Hold torch as flat as possible to the workpiece. Melt surface slightly. Avoid overheating.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175	Availability
			Rods
		I I	L (mm)
3,5 *	DC (-)	x	700
4,0 *	DC (-)	x	700
5,0 *	DC (-)	x	700

* available on request

Reduce excess of acetylene (reduced flame) in oxyacetylene welding.