

UTP LEDURIT 60

Standards :

DIN 8555 : E 10-UM-60-GRZ
EN 14700 : E Fe14

Rutile coated high efficiency stick electrode for high wear resistant claddings against mineral abrasion

Application field

UTP LEDURIT 60 is universally applicable on parts predominantly subject to grinding abrasion combined with light impact, such as conveyor screws, digging teeth, sand pumps and mixer wings. It is also suited as a final layer on tough-hard deposits (UTP DUR 600) or high Mn-steel (UTP BMC).

Welding properties

UTP LEDURIT 60 has excellent welding characteristics and a very easy slag removal. The homogeneous and finely rippled seam surface does, for most applications, not require any finishing by grinding.

Hardness of the pure weld metal approx. 60 HRC
I layer on steel with C = 0,15 % approx. 55 HRC
I layer on high Mn-steel approx. 52 HRC

Weld metal analysis in %

C	Si	Cr	Fe
3,2	1,0	29,0	balance

Welding instruction

Hold stick electrode as vertically as possible, keep a short arc. Preheating is in general not necessary. On multipass-welds a cushion layer with UTP 630 is recommended, in order to prevent hardening cracks in the weld deposit. 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 350	5,0 x 450*
Amperage	A	50 – 80	90 – 120	120 – 150	150 – 200

* available on request