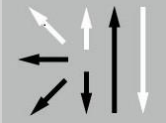


Classifications				
DIN 8555		EN 14700		
MSG 5-GF-40-P		T Fe 3		
Characteristics				
<p>UTP AF ROBOTIC 405 is a seamless medium-alloyed metal-cored wire with low carbon content for wear-resistant surfacing applications.</p> <p>Thanks to its constant wire feed and excellent weldability, this wire is especially suited for automated welding.</p>				
Application field				
<p>Parts of earth moving machinery, rollers and supports. Machinable with sintered hard metal.</p>				
Typical analysis in %				
C	Mn	Si	Cr	Mo
0.1	1.5	0.6	5.5	0.9
Typical mechanical properties				
Hardness as welded: 37 – 42 HRC				
Welding positions				
		Current type: = +	Shielding gas: Ar/CO <sub>2</sub> (EN ISO 14175: M21) Flow rate: 14 – 20 l/min	
Recommended welding parameters				
Diameter [mm]	Spool	Weight [kg]	Amperage [A]	Voltage [V]
1.2	BS300	16	120 – 300	20 – 32
1.6	BS300	16	180 – 420	20 – 34
Other diameters on request				