

## Classifications

DIN 8555	EN 14700
E 1-UM-350	E Fe1

## Characteristics and field of use

UTP DUR 350 is particularly suited for wear resistant surfacings on MnCrV alloyed parts, such as frogs, track rollers, chain support rolls, sprocket wheels, guide rolls etc. The deposit is still machinable with tungsten carbide tools.

UTP DUR 350 has a very good resistance against compression and rolling strain in combination with slight abrasion. The weld metal is machinable with tungsten carbide tools.

Hardness of the pure weld deposit approx. 370 HB  
 1 layer on steel with C = 0.5 % approx. 420 HB

## Typical analysis in %

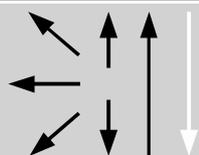
C	Si	Mn	Cr	Fe
0.2	1.2	1.4	1.8	balance

## Welding instruction

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher-tensile steels to 250 – 350 °C.

Stick electrodes that have got damp should be redried for 2 h / 300 °C.

## Welding positions



Current type DC (+) / AC

## Approvals

DB (No. 82.138.03)

## Recommended welding parameters

Electrodes Ø x L [mm]	3.2 x 450	4.0 x 450	5.0 x 450	6.0 x 450
Amperage [A]	100 – 140	140 – 180	180 – 230	240 – 290

\*available on request