

UTP DUR 400

Standards :

DIN 8555 : E I-UM-400
EN 14700 : E Z FeI

Basic coated, high-efficiency welding stick electrode for crack and wear resistant surfacings. Recovery 200 %.

Application field

UTP DUR 400 is used for surfacing parts of non-alloyed and low-alloyed steel and cast steel, subjected mainly to pressure and shock, such as rolls, couplings, stamps, hammers, guide rails etc.

The deposit is still machinable with carbide cutting tools and temperature resistant up to 350° C.

Properties of the weld metal

UTP DUR 400 has a good resistance against impact and pressure wear with low abrasion. The weld metal is machinable with carbide cutting tools and temperature resistant up to 350°C.

Hardness of the pure weld deposit approx. 450 HB
I layer on steel with C = 0,5 % approx. 500 HV
I layer on steel with C = 0,12 % approx. 380 HB

Weld metal analysis in %

C	Si	Mn	Cr	Mo	Fe
0,13	1,5	4,0	1,5	0,5	balance

Welding instruction

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and high-tensile steels to 250 - 350° C. Re-dry stick electrodes that have got damp for 2 h / 300° C.

Current type DC (+) / AC

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	3,2 x 450	4,0 x 450	5,0 x 450
Amperage	A	120 – 160	140 – 190	190 – 260

* available on request