

UTP 7200

Standards :

DIN 8555 : ~ E 7-UM-250-KP
 EN 14700 : EZ Fe9
 AWS A5.13 : ~ E FeMn-A

Basic coated, CrNi alloyed, Mn-hard-steel stick electrode against compression and shock

Application field

UTP 7200 is predominantly suited for tough and crack resistant joinings and surfacings on parts of high Mn-steel subject to extreme impact, compression and shock. Buildups on C-steel are also possible. The main application areas are the building industry, quarries and mines for surfacing worn high Mn steel parts, e.g. excavator pins, buckets and teeth, mill hammers, crusher jaws, cones and beaters, impeller bars, railway building machinery, shunts, heart and cross pieces.

Properties of the weld metal

The high Mn-content produces a fully austenitic deposit. The deposit is highly workhardening and hardens during service from originally 200 - 250 HB to 450 HB. Machining is possible with tung-stene carbide tools.

Hardness of the pure weld deposit

After welding : 200 - 250 HB
 After workhardening : 48 - 53 HRC

Weld metal analysis in %

C	Mn	Ni	Cr	Fe
0,7	13	4,0	4,5	balance

Welding instruction

Hold stick electrode as vertically as possible. Welding should be done at low temperature. Interpass temperature should not exceed 250° C. It is therefore recommended to weld short beads and to allow for continuous cooling during welding or to place the workpiece in a cold water bath with only the welding area sticking out of water.

Current type DC (+) / AC

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	3,2 x 350	4,0 x 450	5,0 x 450
Amperage	A	110 – 140	150 – 180	180 – 210

Approvals

DB (No. 20.138.08)