

# UTP A DUR 250

## Standards :

Material-No. : 1.8401  
 DIN 8555 : MSG I-GZ-250  
 EN 14700 : SZ Fe I

**Copper coated MAG wire for tough but machinable buildups exposed to rolling wear**

## Application field

**UTP A DUR 250** is used for MAG buildups on structural parts subject to rolling wear and where a good machinability is required, such as rails and rail crossings, crane wheels, rollers, couplings, shafts and gear parts.

## Properties of the weld metal

**UTP A DUR 250** has a very good resistance against compression and rolling strain. The weld metal is easily machinable.

**Hardness of the pure weld deposit :** approx. 250 HB

## Weld metal analysis in %

C	Si	Mn	Cr	Ti	Fe
0,3	0,3	1,0	1,0	0,2	balance

## Welding instruction

Machine welding area to metallic bright. Massive parts have to be preheated to 300° C.

## Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175			Availability
		M 12	M 13	M 21	Spools EN ISO 544
1,2	DC (+)	x	x	x	x
1,6 *	DC (+)	x	x	x	x

\* available on request