

UTP 670

Standards :

DIN 8555 : E 6-UM-60
EN 14700 : EZ Fe8

Basic coated hardfacing stick electrode resisting impact, compression and abrasion

Application field

UTP 670 is a high-efficiency stick electrode for hardfacing workpieces of steel, cast steel or high Mn-steel, subject to simultaneous wear by impact, compression and abrasion. Due to its recovery, this stick electrode is ideally suited for economic one-layer applications. Typical applications are crane wheels, rollers, chain links, sprocket wheels, gliding surfaces, screw conveyors, beaters, edge runners, guide wheels, baffle plates etc.

Properties of the weld metal

UTP 670 has a martensitic structure and is suited for impact and compression wear and slight abrasion.

Hardness of the pure weld deposit approx. 58 HRC

Weld metal analysis in %

C	Si	Mn	Cr	Mo	V	Fe
0,4	1,0	1,0	9,5	0,6	1,5	balance

Welding instruction

Hold stick electrode as vertically as possible and keep a short arc. Preheating is generally not necessary. For multipass applications it is advisable to weld cushion layers with UTP DUR 250 and to apply UTP 670 for the last 3 layers. Preheating temperature of high Mn-steels should not exceed 250° C, if necessary intermediate cooling or welding in a water bath. Stick electrodes that have got damp should be redried for 2 h / 300° C.

Current type DC (+) / AC

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 350*	3,2 x 450	4,0 x 450	5,0 x 450
Amperage	A	50 – 70	90 – 120	130 – 160	170 – 210

* available on request