UTP 7200

basic coated, CrNi alloyed, Mn-hardsteel stick electrode

Classifications

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

Characteristics and field of use

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.

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 tungstene carbide tools.

Hardness of the pure weld deposit

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

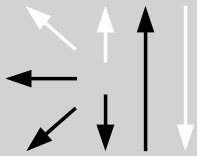
Typical analysis in %

C	Mn	Ni	Cr	Fe
0,7	13,0	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 ticking out of water.

Welding positions



Current type DC (+) / AC

Approvals

DB (No. 20.138.08)

Recommended welding parameters

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