UTP DUR 300

Basic coated welding stick electrode
for medium-hard and tough buildups

Classifications	
DIN 8555	EN 14700
E 1-UM-300	E Fe1

Characteristics and field of use

UTP DUR 300 is indicated for medium-hard surfacings, particularly on structural parts of base materials of higher strength, such as Mn-Mo-alloyed wing and junction rails up to 850 N/mm², e. g. drive wheels, gear parts, crane wheels etc.

Hardness of the pure weld deposit approx. 300 HB
1 layer on steel with C = 0,5 % approx. 350 HB

UTP DUR 300 has a very good resistance against compression and rolling strain. The weld metal is easily machinable.

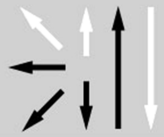
Typical analysis in %

C	Si	Mn	Cr	Fe
0,06	0,7	1,0	3,0	balance

Welding instruction

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher-tensile steels to 250 – 350° C. Stick electrodes that have got damp should be redried for 2 h / 300° C.

Welding positions



Current type DC (+)

Approvals

DB (No. 82.138.04)

Recommended welding parameters

Electrodes Ø x L [mm]	3,2 x 450*	4,0 x 450	5,0 x 450
Amperage [A]	110 – 130	140 – 160	170 – 200

* available on request