UTP CELSIT 706

rutile coated stick electrode on Cobalt base, core wire alloyed

Classifications		
DIN 8555	EN 14700	AWS A5.13
E 20-UM-40-CSTZ	E Z Co2	E CoCr-A

Characteristics and field of use

UTP CELSIT 706 is used for hardfacing on parts subject to a combination of erosion, corrosion, cavitation, impact, pressure, abrasion and high temperatures up to 900° C, such as tight surfaces on fittings, valve seats and cones for combustion engines, gliding surfaces metal-metal, highly stressed hot working tools without thermal shock, milling mixers and drilling tools.

Excellent gliding characteristics, easy polishability, good toughness, nonmagnetic. Machining by grinding or with tungsten carbide cutting tools.

UTP CELSIT 706 has excellent welding properties and a homogenenous, finely rippled seam due to spray arc. Very easy slag removal.

Hardness of the pure weld deposit	40 – 42 HRC
Hardness at 500°C	approx. 30 HRC
Hardness at 700°C	approx. 160 HB

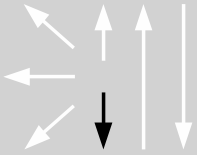
Typical analysis in %

C	Cr	W	Co
1,1	27,5	4,5	balance

Welding instruction

Clean welding area, preheating temperature 450 – 600° C, very slow cooling. Hold stick electrode vertically and with a short arc and lowest possible amperage. Redry stick electrodes that have become damp for 2 h / 300°C.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	3,2 x 350	4,0 x 350	5,0 x 350*
Amperage [A]	70 – 110	90 – 130	110 – 150

*available on request