

## Classifications

DIN 8555
UP 1-350

## Characteristics

Rebuilding and hardfacing alloy for Carbon steel parts.

Microstructure:	Bainite
Machinability:	Good
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	As required

## Field of use

Sliding metal parts, gear teeth, undercarriage links, rollers and idlers, shafts, bushing.

## Typical analysis in %

C	Mn	Si	Cr	Mo	Nb	Fe
0.07	1.4	0.3	4.0	0.5	0.1	balance

## Typical mechanical properties

Hardness as welded: 320 HB

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Flux-Rate [kg per kg wire]	Travel Speed [cm/min]
3.2	325 – 450	26 – 30	35 – 40	1.1	40 – 50