

Classifications

EN 14700

E Fe7

Characteristics and field of use

UTP 665 is especially suitable for repairs on tool steels, particularly cutting tools made of 12-% chromium cutting steels, such as 1.2601, 1.2080, 1.2436, 1.2376, 1.2379, on broken or fatigued areas. Modification of moulds can also be done. The mentioned tool steels are particularly used in the car industry as stamping - and pressing tools.

UTP 665 has excellent welding properties. Smooth, stable arc, spatterfree and fine rippled seams without undercutting. Very good slag removal. The weld deposit is equivalent to high alloyed chromium steel, crack - and pore resistant, stainless.

Hardness of the pure weld metal: approx. 250 HB
 on Cr cutting steel 1 – 2 layers 55 – 57 HRC

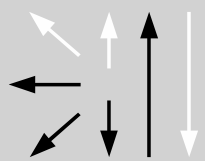
Typical analysis in %

C	Mn	Si	Cr	Fe
0,06	0,8	0,6	17,0	balance

Welding instruction

Preheat 12-% chromium cutting steels to 400 – 450° C in hardened as well as in soft annealed conditions. Soft-annealing and throughout preheating is recommended at massive tools and prolonged working. Generally a local preheating and peening of the welding bead will be enough for smaller repair works. Slow cooling in oven or under a cover.

Welding positions



Current type DC (+) / AC

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 250*	3,2 x 350*	4,0 x 350*
Amperage [A]	50 – 70	70 – 100	100 – 130

*available on request