

Classifications	
DIN 8555	EN 14700
E 3-UM-350-T	E Fe5

Characteristics and field of use

Due to its high-grade structure, UTP 702 is used for repair, preventive maintenance and production of highly stressed cold and hot working tools, such as punching tools, cold shears for thick materials, drawing -, stamping - and trimming tools, hot cutting tools, Al-die cast moulds, plastic moulds, cold forging tools. The weld deposit is, in as-welded condition, easily machinable and the subsequent age hardening optimises the resistance to wear and alternating temperatures.

UTP 702 has excellent welding properties, a smooth and regular drop transfer, good bead appearance and easy slag removal.

Hardness of the pure weld metal:

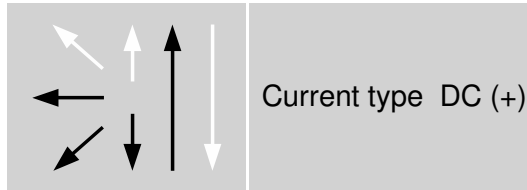
untreated:	34 – 37 HRC
After age hardening 3 – 4 h / 480° C	50 – 54 HRC

Typical analysis in %							
C	Si	Mn	Mo	Ni	Co	Ti	Fe
0,025	0,2	0,6	4,0	20,0	12,0	0,3	balance

Welding instruction

Clean welding area to metallic bright. Only massive tools should be preheated to 100 – 150° C. On lowalloy steels at least 3 – 4 layers should be applied. Keep heat input as low as possible.

Welding positions



Recommended welding parameters			
Electrodes Ø x L [mm]	2,5 x 250	3,2 x 350	4,0 x 350
Amperage [A]	70 – 90	100 – 120	120 – 140