

Classifications															
EN 14700			DIN 8555												
S Z Fe3			MSG 3-GZ-40-T												
Characteristics and field of use															
<p>UTP A 73 G 4 is, due to its excellent hot wear resistance and toughness, used for buildups on hot working tools and structural parts subject to impact, compression and abrasion at elevated temperatures, such as forging dies, die cast moulds, plastic moulds, guides, recipients, continuous casting rolls. Hot wear resistant claddings can be made on non-alloy or low-alloy base materials, such as e. g. boiler tubes in coal burning power stations. The deposit is machinable with cutting tools.</p> <p>UTP A 73 G4 has very good welding properties, good weld buildup and an even flow of the weld pool.</p> <p>Hardness of the pure weld deposit :</p> <table border="0"> <tr> <td>untreated</td> <td>38 – 42 HRC</td> </tr> <tr> <td>soft-annealed 800° C</td> <td>approx. 230 HB</td> </tr> <tr> <td>hardened 1030° C/oil</td> <td>approx. 48 HRC</td> </tr> <tr> <td>tempered 550° C</td> <td>approx. 42 HRC</td> </tr> <tr> <td>1 layer on non-alloy steel</td> <td>approx. 30 HRC</td> </tr> </table>						untreated	38 – 42 HRC	soft-annealed 800° C	approx. 230 HB	hardened 1030° C/oil	approx. 48 HRC	tempered 550° C	approx. 42 HRC	1 layer on non-alloy steel	approx. 30 HRC
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Typical analysis in %															
C	Si	Mn	Cr	Mo	Fe										
0.1	0.4	0.6	6.5	3.3	balance										
Welding instruction															
<p>Machine welding area to metallic bright. Cracks in the base material have to be gouged out completely. Preheating temperature of 400 °C on tools should be maintained. Stress relief/annealing is recommended at 550 °C. Preheating on non- and low-alloy materials is generally not required.</p>															
Approvals															
TÜV (No. 06742)															
Wire diameter [mm]	Current type			Shielding gas (EN ISO 14175)											
1.0	DC (+)			M 12	M 13	M 21	C 1								
1.2	DC (+)			M 12	M 13	M 21	C 1								
1.6	DC (+)			M 12	M 13	M 21	C 1								