

Classifications

EN 14700	DIN 8555	Material-No.
SZ Fe 2	MSG 2-GZ-400	1.8405

Characteristics and field of use

UTP A DUR 350 is suited for MAG buildups on structural parts subject to compression, impact and abrasion, such as caterpillar track components, machine and gear parts, stamps.

The weld deposit of UTP A DUR 350 may be soft annealed and hardened. Post-weld machining by grinding is possible.

Hardness of the pure weld deposit :

untreated	approx. 450 HB
hardened 820 – 850 °C/oil	approx. 62 HRC
soft annealed 720 – 740 °C	approx. 200 HB
1 layer on non-alloyed steel	approx. 350 HB

Typical analysis in %

C	Si	Mn	Cr	Ti	Fe
0.7	0.3	2.0	1.0	0.2	balance

Welding instruction

Machine welding area has to be metallic bright. Massive parts have to be preheated to 200 – 300 °C.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)		
1.0	DC (+)	M 12	M 13	M 21
1.2	DC (+)	M 12	M 13	M 21