

Standards

DIN 8555 : E-3-UM-40-PT

UTP 730 G4

Basic electrode four tough, crack resistant surfacings against compression, impact and abrasion on hot working tools.

Application field

UTP 730 G4 is, due to its toughness and heat resistance, ideally suited for surfacings on parts and tools subject to abrasion, compression and impact at elevated temperatures. Particularly for build-ups on forging dies, die cast moulds, rollers, wobbler drives, hot shear blades.

UTP 730 G4 also offers an economic solution for the production of new tools, for which a base material with an adequate tensile strength is recommended.

Welding properties

The electrode has excellent welding properties, a stable regular flow, good bead appearance and very easy slag removal.

Hardness of the pure weld metal: 37 - 42 HRC

Heat resistant: Up to 550°C

Weld metal analysis in %

C	Si	Mn	Mo	Cr
0,1 – 0,2	0,5	0,6	3 - 4	5 - 7

Welding instruction

Pre heat the workpiece to 400°C. Hold electrodes as vertically as possible and with a short arc. Take care of a slow cooling of the workpiece. Machining is possible with tungsten carbide tools. Re-dry electrodes that have gotten damp to 2 h 300°C.

Current type:

(= +)

Welding positions:



Current adjustment

Electrodes	Ø x L (mm)	2.4mm (3/32") x 350	4.0mm (5/32") x 450	5.0mm (3/16") x 450
Amperage	(A)	80 - 110	110 - 140	130 - 170