

**UTP**

**Standards :** DIN 8555 : E 10-UM-65-GRZ  
 AWS A5.13 : ~E FeCr-A 1



## UTP 7100

**High-efficiency electrode without slag resisting abrasion and moderate impact loads**

### Application field

The high Cr-C-alloyed hardfacing electrode **UTP 7100** is used for surfacings on parts made of constructional steel, cast steel or Mn-steel, which are subject to grinding wear, such as idlers, digging buckets, digging teeth, ploughshares, mixing wings and conveyor screws.

On multi-pass applications it is excellently suitable as buffer layer on high-strength building-up layers UTP DUR 600 or UTP 670. On Mn-hard steels it is advisable to weld the building-up layers with UTP 630 or UTP 7200.

### Welding properties

**UTP 7100** has excellent welding properties. The electrode is also suitable for light out-of-position weldings. Good electric loading, a very stable arc, minimal development of fume, flat and regular seam surface. High deposition rate due to the recovery of 180 %.

**Hardness of the pure weld deposit** 60 - 63 HRC  
 1. layer on St 52 55 HRC

### Weld metal analysis in %

C	Cr	Fe
5	35	balance

### Welding instruction

Hold electrode as vertically as possible and with a short arc. The weld deposit has high hardness values already in the 1. layer due to a low welding amperage and as a result of a low dilution with the base metal.

**Current type :** DC (+) / AC

### Current adjustment :

Electrodes	Ø mm x L	3,2 x 350	4,0 x 350	5,0 x 450*
Amperage	A	90 – 120	110 – 140	130 – 160

\* available on request