

**Classifications** basic-coated stick electrode

DIN 8555 EN 14700

E 3-UM-55-ST E Fe8

### Characteristics and field of use

UTP 73 G 2 is, due to its high hardness, toughness and heat-resistance ideally suited for build-ups on parts subject to severe friction, compression and moderate impact loads at elevated temperatures, such as back centers, gripping pliers, gliding and guiding surfaces, hot and cold punching tools, valves, slides, hot-shear blades, extrusion press pistons, forging tools, stripping columns, trimming tools, roll mandrils or punching tools for sheet metals. UTP 73 G 2 is used to good advantage for the production of new cold and hot working tools. In such cases cladding is made on base material with an accordingly high tensile strength.

The stick electrode has excellent welding properties, a stable and regular flow, good bead appearance and very easy slag removal. Heat-resistant up to 550 °C

Hardness of the pure weld metal: 55 – 58 HRC

### Typical analysis in %

C	Si	Mn	Cr	Mo	Fe
0.35	0.5	1.3	7.0	2.5	balance

### Welding instructions

Preheat the workpiece to 400 °C. Hold stick electrode as vertically as possible and with a short arc. Allow the workpiece to cool down slowly. Finish by grinding. Re-dry damp stick electrodes damp for 2 h / 300 °C.

### Welding positions



Current type DC (+) / AC

### Form of delivery and recommended welding parameters

<i>Electrodes</i> Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
<i>Amperage</i> [A]	60 – 90	80 – 110	100 – 140	130 – 170