

Classifications													
EN 14700	DIN 8555			Material-No.									
SZ Fe 2	MSG 2-GZ-400			1.8405									
Characteristics and field of use													
<p>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.</p> <p>The weld deposit of UTP A DUR 350 may be soft annealed and hardened. Post-weld machining by grinding is possible.</p> <p>Hardness of the pure weld deposit :</p> <table border="0"> <tr> <td>untreated</td> <td>approx. 450 HB</td> </tr> <tr> <td>hardened 820 – 850 °C/oil</td> <td>approx. 62 HRC</td> </tr> <tr> <td>soft annealed 720 – 740 °C</td> <td>approx. 200 HB</td> </tr> <tr> <td>1 layer on non-alloyed steel</td> <td>approx. 350 HB</td> </tr> </table>						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
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Typical analysis in %													
C	Si	Mn	Cr	Ti	Fe								
0.7	0.3	2.0	1.0	0.2	balance								
Welding instruction													
<p>Machine welding area has to be metallic bright. Massive parts have to be preheated to 200 – 300 °C.</p>													
Wire diameter [mm]		Current type		Shielding gas (EN ISO 14175)									
1.0		DC (+)		M 12	M 13								
1.2		DC (+)		M 12	M 13								