

# UTP A DUR 600

## Standards :

Material-No. : 1.4718  
 DIN 8555 : W/MSG 6-GZ-60-S  
 EN 14700 : SZ Fe 8

**Copper coated MAG wire for highly wear resistant surfacings exposed to impact and abrasion**

## Application field

**UTP A DUR 600** is universally applicable for TIG and MAG buildups on structural parts subject to high impact and medium abrasion. Main applications are found in quarries, crushing plants, mines, steel works, cement works as well as cutting tools and dies in the car industry. Despite the high hardness, the deposit is very tough, crack resistant and has an excellent cutting behaviour.

## Properties of the weld metal

Despite the high hardness, the weld deposit of **UTP A DUR 600** is tough, crack resistant and has a good cutting capacity. Machining by grinding possible.

## Hardness of the pure weld deposit

untreated : 54 - 60 HRC  
 soft annealed 800° C : approx. 250 HB  
 hardened 1000° C/oil : approx. 62 HRC  
 1 layer on non-alloyed steel : approx. 53 HRC

## Weld metal analysis in %

C	Si	Mn	Cr	Fe
0,5	3,0	0,5	9,5	balance

## Welding instruction

Grind the welding area to metallic bright. Generally, only tool steels have to be preheated to 450° C.

## Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175					Availability	
		I 1	M 12	M 13	M 21	C 1	Spools EN ISO 544	Rods EN ISO 544
0,8	DC (+)		x	x	x	x	x	
1,0	DC (+)		x	x	x	x	x	
1,2	DC (+)		x	x	x	x	x	
1,6	DC (+)		x	x	x	x	x	
1,6	DC (-)	x						x
2,0	DC (-)	x						x
2,4	DC (-)	x						x
3,2	DC (-)	x						x