

UTP 65 D

Universal high alloyed stick electrode for a wide range of repair applications

Product features	Customer benefits
» High-alloyed universal electrode	» Ideally suited for a variety of welding tasks
» Self-detaching slag	» Significant time savings, no reworking by tapping or grinding of slag is necessary
» Excellent positional weldability	» No time-consuming re-positioning of components » Better accessibility in difficult-to-reach areas
» Smallest diameters from 1.6 mm	» Suitable for very thin sheets and delicate repair work » Weldable at very low amperage
» High strength of the weld metal	» Suitable for repairing highly stressed components » Good wear resistance of the welded surface

UTP 65 D: For the highest demands in repair and weld overlays

UTP 65 D provides excellent crack resistance when joining hard-to-weld steels such as manganese steel, tool steel, spring steel, and high-speed steel, as well as when welding dissimilar steel combinations. Its good corrosion resistance, tensile strength, and abrasion resistance make it ideal for repair and maintenance of machine and transmission parts such gears, cams, shafts, axles, hot-cutting tools, hot-trimming plates, and dies. It is also highly suitable as a tough buffer layer beneath hardfacing alloys.

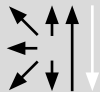
UTP 65 D offers outstanding welding properties: a stable arc, minimal spatter, fine-rippled bead appearance, and very easy slag removal—partly self-detaching. It can be easily welded in all positions except vertical down. Stainless, hot and cold hardening. Hardness of pure weld metal: approx. 260 HB.



Main applications

- » General repair welding
- » Crack repairs
- » Hard-to-weld steels
- » Dissimilar joints

UTP 65 D

Classification			
EN 14700 / EN ISO 3581-A	Welding positions	Polarity	Approvals
E Z Fe11 / EZ 29 9 R 12		DC+ / AC	DB (No. 82.138.01)

Typical all-weld metal analysis in %					
C	Si	Mn	Cr	Ni	Fe
0.1	1.0	1.0	30.0	9.5	balance

Recommended welding parameters	
Electrodes Ø x L [mm]	Amperage [A]
1.6 x 250	35 - 45
2.0 x 250	45 - 60
2.5 x 250	55 - 75
3.2 x 350	75 - 115
4.0 x 350	100 - 145
5.0 x 350	120 - 195

UTP 65 D Packaging				
Dry System (vacuum packaging)	Dimension Ø x L [mm]	Weight in kg	Pieces (approx.)	Item number
 	2.5 x 250 mm	1.2 kg	85	49362
	3.2 x 350 mm	2.5 kg	78	95625
	4.0 x 350 mm	2.5 kg	54	95624

Other dimensions or packaging available on request