

UTP BMC

Standards :

DIN 8555 : E 7-UM-250-KPR
 EN 14700 : E Fe9

Basic coated Chromium alloyed Mn-steel stick electrode for high wear resistant claddings, stainless

Application field

UTP BMC is suitable for claddings on parts subject to highest pressure and shock in combination with abrasion. Surfacing can be made on ferritic steel as well as austenitic hard Mn-steel and joints of hard Mn-steel can be welded.

Main application fields are in the mining- and cement industry, crushing plants, rail lines and steel works, where working parts are regenerated, such as breaker jaws, paving breakers and beating arms, frogs and cross pieces, roll shafts, flight pushers and wobbler drives.

Properties of the weld metal

Fully austenitic structure. Due to the addition of Cr, increased resistance against friction and corrosion. Very high workhardening and high toughness.

Hardness of the pure weld deposit

After welding : approx. 260 HB
 After work hardening : 48 - 53 HRC

Weld metal analysis in %

C	Si	Mn	Cr	Fe
0,6	0,8	16,5	13,5	balance

Welding instruction

Hold the stick electrode nearly vertical. Welding should be done at low temperature. Interpass temperature should not exceed 250° C. It is therefore recommended to weld short beads and to allow for continuous cooling or to place the workpiece in a cold water bath with only the welding area sticking out of water. Re-drying: 2h/300° C

Current type DC (+) / AC

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	3,2 x 450	4,0 x 450	5,0 x 450
Amperage	A	110 – 150	140 – 190	190 – 240