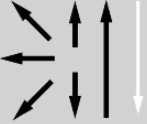


Classifications						
DIN 8555			DIN EN 14700			
E 1 UM 250			E Z Fe 1			
Characteristics and typical fields of application						
<p>The basic-coated electrode UTP Tensasoudo 75 is designed for joining high-tensile steels. Additionally, it is used for surfacings when good mechanical properties and good machinability are required.</p> <p>The main applications of UTP Tensasoudo 75 are re-building of rails, frogs and crane wheels, axles, steel rollers and teeth of gears. UTP Tensasoudo 75 is also suited for buffering and build-up of low-alloyed steels.</p> <p>Hardness of all-weld metal: approx. 230 HB</p>						
Typical analysis of all-weld metal (wt.-%)						
C	Mn	Si	Cr	Mo	Ni	Fe
0.08	1.5	0.5	0.2	0.4	0.7	balance
Welding instruction						
<p>The angle between the plate and the electrode should be kept between 80-90°. Preheat heavy parts and higher-carbon steel qualities to 150 – 300°C. Re-dry damp electrodes for 2 h at 300° C.</p>						
Operating data						
		<p>Polarity DC (+) / AC</p>				
Recommended welding parameters						
Electrodes Ø x L [mm]	3.2 x 350	4.0 x 350	5.0 x 450	6.0 x 450		
Amperage [A]	110 – 140	130 – 175	170 – 230	200-280		