

WEARstick Tool NiCrMo+ (UTP 7000)

High efficient stick electrode, NiCrMoW-alloyed, rutile coated

Classifications								
EN 14700				DIN 8555				
E Z Ni2				E23-UM-200-CKTZ				
Characteristics and typical fields of application								
WEARstick Tool NiCrMo+ is particularly suited for wear resisting cladding on working surfaces of hot working tools subject to thermal load, such as forging jaws, forging dies, forging saddles, hot piercing plugs, hot cutting tools, hot trimming tools, roll mandrils, hot moulding plugs.								
WEARstick Tool NiCrMo+ has excellent welding properties, a regular and finely rippled bead appearance due to spray arc. Very easy slag removal. The weld deposit is highly corrosion resistant, scale resistant and workhardening. Machinable with cutting tools.								
Hardness of the pure weld deposit : approx. 220 HB after workhardening: approx. 450 HB								
Typical analysis								
2	Si	Mn	Cr	Ni	Мо	W	Со	Fe
).04	0.3	0.9	16.0	bal.	17.0	5.0	1.5	5.0
Operating data								
▶ † † Polarity		DC + / AC			Dimension mm		Current A	
Redrying		300°C / 2 h			2.5 × 350		80 - 100	
					3.2 × 350		100 – 120	
					4.0 × 350		130 – 160	
					5.0 imes 450		180 – 220	
	and typic: rMo+ is par g jaws, forg rMo+ has e leposit is hi e weld dep g: approx. 4 : .04 Polarity Redrying	and typical fields of rMo+ is particularly suite g jaws, forging dies, forg rMo+ has excellent weldi leposit is highly corrosior e weld deposit : approx. 3 g: approx. 450 HB Si .04 0.3 Polarity Redrying	and typical fields of application rMo+ is particularly suited for wear regins, forging dies, forging saddles, f	and typical fields of application rMo+ is particularly suited for wear resisting cladd g jaws, forging dies, forging saddles, hot piercing p rMo+ has excellent welding properties, a regular a leposit is highly corrosion resistant, scale resistant e weld deposit : approx. 220 HB g: approx. 450 HB Si Mn Cr .04 0.3 0.9 Polarity DC + / AC Redrying 300°C / 2 h	Image: Display state of the system of the	DIN 8555 E23-UM-200-CKTZ E23-UM-200-CKTZ and typical fields of application rMo+ is particularly suited for wear resisting cladding on working surfaces of f g jaws, forging dies, forging saddles, hot piercing plugs, hot cutting tools, hot t rMo+ has excellent welding properties, a regular and finely rippled bead appeate teposit is highly corrosion resistant, scale resistant and workhardening. Machine e weld deposit : approx. 220 HB g: approx. 450 HB Ni Mo Si Mn Cr Ni Mo .04 0.3 0.9 16.0 bal. 17.0 Polarity DC + / AC Dimension m 3.2 × 350 4.0 × 350 A S00°C / 2 h 2.5 × 350 4.0 × 350	DIN 8555 E23-UM-200-CKTZ and typical fields of application rMo+ is particularly suited for wear resisting cladding on working surfaces of hot working to g jaws, forging dies, forging saddles, hot piercing plugs, hot cutting tools, hot trimming tools rMo+ has excellent welding properties, a regular and finely rippled bead appearance due to leposit is highly corrosion resistant, scale resistant and workhardening. Machinable with cut e weld deposit : approx. 220 HB g: approx. 450 HB E Si Mn Cr Ni Mo W QPOlarity POlarity DC + / AC Dimension mm Redrying Si 00°C / 2 h 2.5 × 350 Asto is so is so is so is so is is so is i	DIN 8555 E23-UM-200-CKTZ and typical fields of application rMo+ is particularly suited for wear resisting cladding on working surfaces of hot working tools subject to g jaws, forging dies, forging saddles, hot piercing plugs, hot cutting tools, hot trimming tools, roll mandrils rMo+ has excellent welding properties, a regular and finely rippled bead appearance due to spray arc. Ver leposit is highly corrosion resistant, scale resistant and workhardening. Machinable with cutting tools. Ver leposit is highly corrosion resistant, scale resistant and workhardening. Machinable with cutting tools. e weld deposit : approx. 220 HB g: approx. 450 HB Ver leposit is nighly corrosion resistant. Ver leposit is nighly corrosion. Ve

Welding instructions

Clean welding area, preheat tools to 350 – 400 °C and maintain this temperature during the whole welding process. Slow cooling in an oven. Hold stick electrode vertically and with a short arc. Select lowest possible amperage, in order to reduce dilution with the base metal. Cracks in the tool have to be gouged out completely and welded with UTP 7015 or Thermanit Nicro 82. Final layers have to be welded with WEARstick Tool NiCrMo+.

Approvals