

Classifications

DIN 8555	EN 14700	AWS A 5.21
G/WSG 20-GO-40-CSTZ	R Z Co2	ER CoCr-A

Characteristics and field of use

UTP A CELSIT 706 V is suitable for hardfacing of parts subject to a combination of erosion, corrosion, cavitation, pressure, impact, abrasion and high heat up to 900°C, such as tight surfaces of fittings, valve seats and cones for combustion engines, gliding surfaces metal to metal, highly stressed hot working tools without thermal shock, milling, mixing and drilling tools.

Excellent gliding characteristics, very good polishability, high toughness, non-magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of pure weld deposit: 40 – 42 HRC
Hardness at 500°C: approx. 33 HRC

Rod analysis in %

C	Cr	W	Co
1.2	27.0	4.5	balance

Welding instruction

Clean welding area, preheating temperature 450-600°C, very slow cooling.

Welding procedure and availability

Ø x length	Current type	Shielding gas (EN ISO 14175)
3.2 x 1000 mm	DC (-)	I 1
4.0 x 1000 mm	DC (-)	I 1
5.0 x 1000 mm	DC (-)	I 1

Adjust acetylene excess (reducing flame) in oxyacetylene welding.