

## Classifications

<b>AWS A5.21 / SFA-5.21</b>	<b>DIN 8555</b>	<b>EN 14700</b>
~ERCoCr-B	WSG 20-G0-50-CSTZ	R Co3

## Characteristics and typical fields of application

UTP A CELSIT 712 SN is suitable for highly wear resistant hardfacing of parts subject to a combination of abrasion, erosion, cavitation, corrosion, pressure and high heat up to 900° C, such as running, sealing and gliding faces of fittings and pumps, valve seats and cones for combustion engines, tools for the wood, paper and plastic industry, gliding surfaces metal to metal, milling, mixing and drilling tools, heavy-duty hot working tools without thermal shock.

Properties of the weld metal Excellent gliding characteristics, good polishability, slightly magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of pure weld deposit: 48 – 50 HRC

Hardness at 500°C: approx. 40 HRC

## Typical analysis

	C	Cr	W	Co
wt.-%	1.8	29	8.5	Bal.

## Operating data

<b>Polarity</b>	DC –	<b>Dimension mm</b>
<b>Shielding gas (EN ISO 14175)</b>	I 1	3.2 × 1000
		4.0 × 1000
		5.0 × 1000

## Welding instructions

Clean welding area, preheating temperature 500 – 600° C, very slow cooling.

## Approvals

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