

## Classifications

DIN 8555	EN 14700	AWS A5.13
E 10-UM-60-GRZ	E Fe14	EFeCr-A8 (mod.)

## Characteristics and field of use

UTP LEDURIT 61 is suited for highly wear resistant claddings on parts subject to strong grinding abrasion combined with medium impact, such as conveyor screws, scraper blades, bucket teeth, mixer wings, sand pumps. Also as a final layer on crusher jaws.

### Welding properties

UTP LEDURIT 61 has excellent welding characteristics and a very easy slag removal. The homogeneous and finely rippled seam surface does, for most applications, not require any finishing by grinding.

Hardness of the pure weld deposit	approx. 60 HRC
1 layer on steel with C = 0,15 %	approx. 55 HRC
1 layer on high Mn-steel	approx. 52 HRC

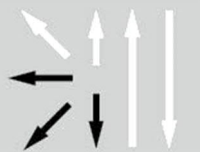
## Typical analysis in %

C	Si	Cr	Fe
3.2	1.3	32.0	balance

## Welding instruction

Hold stick electrode as vertically as possible, keep a short arc. Preheating is in general not necessary. Stress relief cracks occur in multipass-applications. Therefore, a cushion layer with UTP 630 is recommended. Re-dry stick electrodes that have got damp for 2h/300° C.

## Welding positions



Current type DC (+) / AC

## Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Amperage [A]	80 – 100	90 – 130	130 – 180	140 – 190