

UP-F

Crack-Free Ferrous Based Anti-Wear Overlay

UP-F can be applied on which suffer wear and impaction simultaneously, crack-free surface can protect base plate from corrosive environment.

HARDNESS	740 ± 20 HV					
TYPICAL COMPOSITION (wt %)	C	Cr	Mn	Si	Fe	Other
	2.0	4.8	0.4	1.1	Bal.	Mo, V, W
AVAILABLE THICKNESS (mm)	A: Overlay ≥ 2 mm B: Base plate ≥ 4 mm (A≤B)					
AVAILABLE SIZE (mm)	1000 x 1000					
ADVANTAGES	< 5% dilution conduces to less deformation Higher wear resistance than High Speed Steel M2, M4 Thin overlay with high wear resistance is achievable					
OPERATION TEMPERATURE	< 600 °C					
ASTM G65 Procedure A	0.16-0.18 (Undiluted Deposit)					
MACHINABILITY	Plasma cutting, Saw cutting, Laser cutting, Water jet cutting, EDM, Gouging, Countersink, Stud bolt					
FORMABILITY	Minimum Radius: 150 mm (for 6+4, with overlay inward) Suggested: using hydraulic press machine to bend UP-F					
APPLICATION	Wear plate, Bucket teeth, Liner, Plunger, Cutting knife, Grader blade, Spiral dewaterer blade					

