

## UPW-266

Hardfacing open arc welding wire

Features	UPW-266 is a high carbon, high chromium self-shielded hardfacing welding wire. It is specially designed for wear plate manufacturing. The deposited metal is suitable for parts where medium impact and abrasion resistance are required. Due to containing a lot of chromium carbides in the microstructure, the weld deposit is non-machinable.	
Applications	Wear plates manufacturing, the reclamation of worn Ni-hard or high chromium cast iron rollers in grinding mill, coal crusher and table segments in coal firing power stations and vertical mills in cement plants.	
Typical Chemistry	C 5.4%, Mn 0.7%, Si 0.9%, Cr 28.5%	
Hardness	58 ~ 66 HRC (undiluted deposit)	
Size	2.8 mm	
Package	Drum packing in 250 kg	
Recommended welding parameters	Voltage	27 ~ 30 V
	Current	300 ~ 400 A
	E.S.O.	30 ~ 40 mm