

## UPW-613

Open arc welding wire for build-up

Features	The deposit metal is a 17%Cr ferritic stainless steel. UPW-613 has a very good workability, less spatters, easy-to-remove slag, stable arc and excellent porosity resistance. It is specially designed for use as a buffer layer before subsequent 13%Cr martensitic stainless steel overlay.	
Applications	For build-up of continuous casting rolls and table rolls in steel mills.	
Typical Chemistry	C 0.06%, Mn 0.8%, Si 0.6%, Cr 18.1%	
Hardness	18~24 HRC (undiluted deposit)	
Size	2.4 mm	
Package	Drum packing in 250 kg or 150 kg	
Recommended welding parameters	Voltage	26 ~ 28 V
	Current	250 ~ 400 A
	E.S.O.	25 ~ 35 mm