

UPW-614

Hardfacing open arc welding wire

Features	UPW-614 is a self-shielded flux cored wire for metal-to-metal applications. The deposit metal is a nitrogen containing 13%Cr martensitic stainless steel. UPW-614 has a very good workability, less spatters, easy-to-remove slag, stable arc and excellent porosity resistance. Due to the advanced manufacturing process and the agglomeration of flux, the instability of nitrogen content along the weld metal can be solved and further improving the service life.	
Applications	Suitable for hardfacing on continuous rollers and table rollers in steel mills.	
Typical Chemistry	C 0.04%, Mn 0.7%, Si 0.5%, Cr 13.1%, Mo 0.5%, Ni 4%, N 0.12%	
Hardness	40~45 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