

UPW-615

Open arc welding wire for build-up

Features	A high chromium, high manganese alloy is suitable for joining of 14% Mn steel and buffer layer for carbon steel. The deposit metal is fully austenitic and can be easily work hardened through heavy impact or shock load.	
Applications	It is suitable for railway rail, crossovers, gyratory crusher mantles, shovel teeth, buffer layer for coal crushers, etc.	
Typical Chemistry	C 0.4%, Mn 16%, Si 0.5%, Cr 13%	
Hardness	18~24 HRC (as welded, undiluted deposit) 45~55 HRC (worked hardened, undiluted deposited)	
Size	2.8 mm	
Package	Drum packing in 250 kg	
Recommended welding parameters	Voltage	27 ~ 32 V
	Current	300 ~ 450 A
	E.S.O.	25 ~ 35 mm