

## UPW-616

Open arc welding wire for build-up

Features	UPW-616 is an austenitic stainless steel welding wire. The chemical composition of weld deposit being very similar to SUS307 make it a very suitable candidate for joining or building up of hard-to-weld or dissimilar steels.	
Applications	Joining of wear plates, rebuilding of rails, crossings, buffer layer for roller press.	
Typical Chemistry	C 0.05%, Mn 6.0%, Si 0.7%, Cr 18.1%, Ni 8.2%	
Hardness	170 HB (undiluted deposit)	
Size	2.8 mm	
Package	Drum packing in 250 kg	
Recommended welding parameters	Voltage	26 ~ 30 V
	Current	300 ~ 400 A
	E.S.O.	30 ~ 40 mm