

UPW-629

Hardfacing open arc welding wire

Features	UPW-629, a complex carbide welding wire, is designed to fight against high temperature abrasive environment up to 800°C by adding Cr, Mo, Nb, V and W elements. The deposit forms extremely hard carbide which can be used for hardfacing against extremely abrasion wear.	
Applications	Sinter crusher and grizzly bars in sinter plant, screens, top feeder spout, distribution chute in blast furnace and where high temperature and severe abrasion are considered.	
Typical Chemistry	C 5.3%, Mn 1.3%, Si 1.0%, Cr 22%, Nb 6.5%, Mo 6.5%, V 1.0%, W 2.0%	
Hardness	62 ~ 69 HRC (undiluted deposit)	
Size	2.8 mm	
Package	Drum packing in 250 kg	
Recommended welding parameters	Voltage	27 ~ 30 V
	Current	300 ~ 450 A
	E.S.O.	30 ~ 40 mm