

UPW-645

Hardfacing open arc welding wire

Features	UPW-645 is designed to produce a high-alloyed martensitic steel that can be exposed to very abrasive wear in combination with high impact stress. The microstructure of deposit is martensite with small uniformly distributed Niobium carbides. The weld metal can be heat treated and forged.	
Applications	Cement clinker crusher rolls, roller press, shovel bucket teeth and lips, crusher hammers, asphalt mixer blades, agricultural tools, cane knives and shredders.	
Typical Chemistry	C 1.6%, Mn 0.9%, Si 0.9%, Cr 6.5%, Nb 5.5%	
Hardness	45 ~ 55 HRC (3 layers)	
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