

UPW-H

Hardfacing welding electrode

Features	UPW-H is a high carbon, high chromium hardfacing welding electrode. It is specially designed for wear plate manufacturing. The deposited metal is suitable for parts where medium impact and abrasion resistance are required. Due to containing a lot of chromium carbides in the microstructure, the weld deposit is non-machinable.	
Applications	Wear plates manufacturing, anti-abrasion liner, the reclamation of worn Ni-hard or high chromium cast iron rollers in grinding mill, coal crusher and table segments in coal firing power stations and vertical mills in cement plants.	
Typical Chemistry	C 5.9%, Mn 1.1%, Si 1.1%, Cr 33.2%, others < 2%	
Hardness	58 ~ 66 HRC (undiluted deposit)	
Size	φ3.2, φ4.0	
Package	5 kg in a plastic tube	
Recommended welding Current (A)	φ3.2	φ4.0
	100-140	140-200