



UPW-614 deposit is classified as the 13% Cr martensitic stainless steel with nitrogen dissolved in it to enhance precipitation hardening. Unique chemical composition design not only brings remarkable workability, such as easy-to-remove slag and stable arc with less spatters during welding, but also effectively suppresses the porosities.

## Hardfacing on the continuous casting rollers and table rolls (conveyor rolls) in steel mills

<b>Composition</b>  Fe-Cr-Ni-Mo	<b>Microstructure</b>  Martensite Ferrite	<b>Typical Weld Deposit Mechanical Property</b>  37~44 HRC
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Diameter (mm)	Type	Voltage	Current	Stick-out	Packing
Ø2.4	DC+	26~30V	250~400A	25~35mm	250 kg in drum