

UPW-812

EN
DIN

14700 T Fe7
8555: UP-5-GF-50-C



Deposit Characteristic

UPW-812 is an optimized 13% Cr martensitic stainless steel wire for submerged arc welding. To avoid the cracks generating during welding process, workpiece preheating is necessary and the interpass temperature should be controlled in the range of 200-420 °C especially for the massive and highly stressed workpieces.

Recommended Application

Hardfacing on the continuous casting rollers, table rolls (conveyor rolls) and other rolls used in hot rolling production line in steel mills

Composition	Microstructure	Flux	Typical Weld Deposit Mechanical Property
Fe-Cr	Martensite	UPW-882 (sintered type)	46~52 HRC

Diameter (mm)	Type	Voltage	Current	Stick-out	Packing
Ø3.2	DC+	26~32V	250~450A	25~35mm	250 kg in drum 50 kg wire spool