

UPW-819

EN
DIN

14700 T Fe13
8555: UP-5-GF-300-P



Deposit Characteristic

Multilayer UPW-819 deposit features low impurity contents, high impact resistance and low losses of mechanical properties at the elevated temperature. It can be applied on the high carbon steel, such as S45C, S50C, S60C, etc. up to 20 mm thickness without generating micro-fissures.

Recommended Application

Buffer layers of the tool steel hard layers
Hardfacing on high carbon steel crane wheels, idlers, mining car wheels and other components which suffer from metal-to-metal abrasion wear

Composition	Type of Steel	Flux	Typical Weld Deposit Mechanical Property
Fe-Mo-Mn-Cr	Low alloy steel	UPW-882 (sintered type)	26~32 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