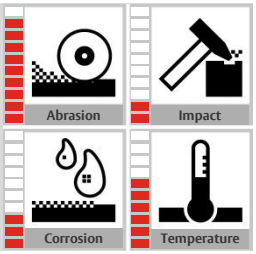
VAUTID Ultra 302

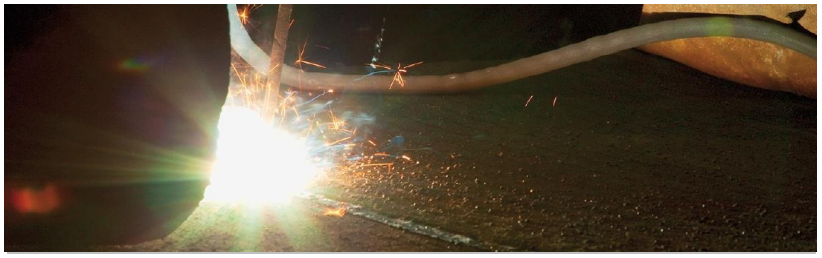
Welding Rod

Hardfacing material for extreme abrasion and low impact

VAUTID

VAUTID Material characteristics





Specification	**Welding rod DIN EN 14700 E Fe20 g**
Material type **Alloy components**	Hard tungsten carbides with a grain size of 0,25 – 0,7 mm embedded in a wear-resistant ledeburitic matrix. Fe – W2C – WC
Weld deposit characteristics	VAUTID Ultra 302 consists of the hardened matrix with embedded tungsten carbides. The weld deposit is magnetic and cannot be machined. Multi-layer welding with up to three layers is possible. VAUTID Ultra 302 exhibits low shock resistance
Weld deposit properties	Hardness of the matrix: ca. 700 - 900 HV10* Tungsten carbides: ca. 2000 HV10* (DIN 32525-4)
Recommended applications	Core drilling tips, roller bore tips, deep well drilling tools, agitator blade webs, plough blades, grinding segments, strippers
Standard sizes	Diameters: 3,25 / 4,0 / 5,0 / 6,0 mm Length: 350 mm Packing: 5 kg packages

* subject to common industrial fluctuations

Welding instructions:

VAUTID Ultra 302 can be welded with D.C. (+ pole) and A.C. .Due to the colder arc, A.C. is preferable in order to avoid a strong melting of the tungsten carbides. Stringer bead technique shall be used rather than weave bead technique. Keep the welding current as low as possible

Diameter (mm)	Current (A)
3,25	55 - 75
4,0	70 – 90
5,0	90 – 120
6,0	110 – 140

Welding position (EN ISO 6947): PA

This data sheet corresponds to the present state of production (October 2016) and can be changed anytime.

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