

Classifications

DIN 8555	EN 14700
MSG 6 – GF – 60 – GP	T Fe 6

Characteristics and field of use

UTP AF ROBOTIC 606 is a seamless, chromium-molybdenum-alloyed, metal-cored wire for wear-resistant hardfacing applications up to 700°C. For steels that are difficult to weld, a buffer layer of BÖHLER Kb 52 T-FD should be applied.

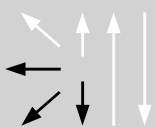
Application field:

Parts of earth moving machinery, rollers and mills.

Hardness as welded: 57 – 62 HRC

C	Mn	Si	P	S	Cr	Mo
0.5	1.5	0.6	<0.025	<0.025	5.5	0.6

Welding positions



Current type: = +

Shielding gas: Ar/CO₂ (EN ISO 14175: M21)

Flow rate: 14 - 20 l/min

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]
1.0	40-270	11-32
1.2	50-320	12-35
1.4	60-380	14-36
1.6	60-420	16-38
2.0	100-450	17-40
2.4	150-500	18-42

Supply form

On spools B 300 of approx. 16 kgs

Other spool types on request.