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## RAILWAYS INDUSTRY



MAINTENANCE & REPAIR

To increase your productivity,  
optimize maintenance and repair  
with long-life filler metals

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*We join forces...*

**YOUR CHALLENGING APPLICATION: OUR COMPLETE SOLUTION**

**RAILWAYS INDUSTRY**

**soudokay** Your specialist for hardfacing cored wires and strip cladding

	FCAW STRIP ESW	HARDNESS	DESCRIPTION	Weld metal analysis in %							
				C	Si	Mn	Cr	Mo	Ni	Ti	Fe
Switches	SK 218-O	As welded: approx. 200 HB After work hardening: up to 450 HB	Maintenance of austenitic manganese castings	0,9	0,6	14,0	3,5		0,4		Bal.
	SK 219-O	As welded: approx. 220 HB After work hardening: up to 450 HB	Maintenance of austenitic manganese castings, hard facing of rails	1,2	0,3	21,0	5,0				Bal.
	SK AP-O SK SMC-O	As welded: approx. 200 HB After work hardening: up to 525 HB	Rebuilding and joining of carbon and 14% manganese steels, buffer layer prior to deposit hard overlay, hard facing of castings and rails either, welding castings to rails	0,4	0,4	16,0	12,8				Bal.
Rails	SK 242-O	As welded: approx. 40 HRC	Maintenance and hardfacing of underground rails, wheels rebuilding	0,1	0,7	0,7	2,4			0,9	Bal.
	SK 300-O	As welded: approx. 285 HB	Self shielded flux-cored wire to be used for the rebuilding of Carbon steel parts.	0,1	0,6	1,0	0,5	0,4		0,9	Bal.
	SK 307-G	As welded: approx. 155 HB After work hardening: up to 425 HB	Railways and tramway lines, building up and buttering before hardfacing, wheel flanges rebuilding	0,1	0,9	7,1	17,3		8,5		Bal.
	SK 232-O	As welded: approx. 170 HB	Maintenance and hardfacing of underground rails, wheels rebuilding	0,1	0,5	0,8				2,9	Bal.
	SK 309L-O	As welded: approx. 170 HB	Corrosion resistant overlays on rail heads submitted to corrosive action, repair, surfacing or welding of rails or austenitic manganese casting either. Switch blades rebuilding, rust resisting deposit for tract circuiting.	0,03	0,9	0,8	23,0		12,0		Bal.
	SK 402-O	As welded: approx. 160 HB	Repair, surfacing or welding of rails or austenitic manganese casting either. Switch blades rebuilding, rust resisting deposit for tract circuiting.	0,1	0,9	6,0	18,0		7,8		Bal.
	SK 402-G	As welded: approx. 170 HB	Austenitalloy type CrNiMn designed for joining dissimilar metals and for buffer layer deposits prior to hard surfacing.	0,1	0,7	6,6	17,1		7,8		Bal.
	SOUDOTAPE 309L + RECORD EST 307	-	Top rail corrosion resistant overlaying in a single layer using electroslag stripcladding at high deposition rates	0,1	0,4	4,3	19,3		10,7		Bal.

**UTP** Your specialist for stick electrodes, TIG, MIG and SAW wires

	SMAW	HARDNESS	DESCRIPTION	Weld metal analysis in %							
				C	Si	Mn	Cr	Mo	Ni	Ti	Fe
Switches	UTP CHRONOS	As welded: approx. 220 HB After work hardening: up to 550 HB	Welding consumable suitable for buildups on high Mn-steel of the same and of similar nature and on C-steels.	0,9	0,8	13,0					Bal.
	UTP 7200 S	As welded: appr. 200-250 HB After work hardening: up to 400-450 HB	Basic coated, CrNi alloyed Mn hard-steel stick electrode for joining and surfacing against extreme impact, compression and shock.	0,7		13,0	4,5		4,0		Bal.
	UTP BMC	As welded: appr. 260 HB After work hardening: up to 550 HB	Welding consumable designed for buildups on parts made of high Mn-steel subject to high compression and impact in combination with abrasion.	0,6	0,8	16,5	13,5				Bal.
Rails	UTP DUR 250	As welded: appr. 270 HB 1 layer on steel with C=0,5% appr. 320 HB	Basic coated stick electrode for tough, easily machinable buildups.	0,2	1,1	1,2	0,8				Bal.
	UTP DUR 300	As welded: appr. 300 HB 1 layer on steel with C=0,5% appr. 350 HB	Basic coated stick electrode for wear resistant surfaces on low alloyed steel parts.	0,1	0,7	1,2	1,3				Bal.
	UTP DUR 350	As welded: appr. 300 HB 1 layer on steel with C=0,5% appr. 420 HB	Basic coated electrode for wear resistant surfaces on carbon low alloyed steel parts.	0,2	1,2	1,4	1,8				Bal.
	UTP 614 Kb	-	Double coated stick electrode for highly stressed joints. Particularly suited for rail joint welds.	0,06	0,7	0,9					Bal.
	UTP 630	As welded: appr. 200 HB After work hardening: up to 350 HB	Fully austenitic welding electrode for buffer layers and crack resistant joints.	0,1	0,8	6,0	19,0		9,0		Bal.

Above mentioned electrodes are also available as solid MIG/MAG wires, TIG rods and SA wire flux combinations.



- > SK 300-O
- > SK 242-O
- > SK AP-O
- > SK 402-O
- > SK 402-G
- > UTP DUR 300
- > UTP DUR 350
- > UTP BMC
- > UTP 614 KB
- > UTP 630
- > UTP BMC
- > SK AP-O
- > SK 218-O
- > SK 219-O
- > SK SMC-O
- > SK 14 MN-O
- > SK 313-O
- > SK 242-O
- > UTP CHRONOS
- > UTP 7200 S
- > UTP DUR 350