

Classifications				
Material-no.		EN ISO 24373		
2.1056		S Cu 5410 (CuSn12P)		
Characteristics and field of use				
<p>UTP A 320 is used for welding of copper-tin-alloys with more than 8% Sn, copper-zinc-alloys and copper-tin-zinc-lead alloys, as well as for claddings on cast-iron materials and steel.</p> <p>The weld metal is seawater resistant.</p>				
Typical analysis in %				
Sn	P	Cu	Fe	
12.0	< 0.35	balance	< 0.1	
Mechanical properties of the weld metal				
Yield strength R _{p0.2}	Tensile strength R _m	Hardness	El. conductivity	Melting range
MPa	MPa	HB	s·m/mm ²	°C
140	300	150	7-9	825 – 990
Welding instruction				
Clean the weld area thoroughly. If wall thickness is > 8 mm, preheating to 100-250°C is necessary.				
Wire diameter [mm]	Current type		Shielding gas (EN ISO 14175)	
1.0 mm	= +		I 1	I 3
1.2 mm	= +		I 1	I 3
1.6 mm	= +		I 1	I 3