

Classifications

EN ISO 24373	AWS A5.7	Material-No.
S Cu 6100 (CuAl7)	ER CuAl-A 1	2.0921

Characteristics and field of use

UTP A 34 is used for copper aluminium alloys (aluminium bronzes) with 5 – 9 % Al, copper-zinc alloys (brass and special brass). Weld cladding on cast iron materials and steel.

The weld deposit of UTP A 34 is resistant to corrosion and seawater and has good gliding properties metal-metal. UTP A 34 is easy weldable and obtains a clean weld surface.

Typical analysis in %

Mn	Ni	Cu	Al	Fe
< 0.5	< 0.5	balance	8.0	< 0.5

Mechanical properties of the weld metal

Yield strength $R_{P0.2}$	Tensile strength R_m	Elongation A_5	Hardness	El. conductivity	Melting range
MPa	MPa	%	HB	s·m/mm ²	°C
180	400	40	120	8	1030 – 1040

Welding instruction

The weld seam area has to be machined to a metallic bright by grinding, sand blasting or pickling in order to avoid crack formation or the development of pores.

Approvals

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Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
1.0	DC (+)	I 1
1.2	DC (+)	I 1
1.6	DC (+)	I 1