

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 _{PO,2}	Tensile strength R _m	Elongation A ₅	Hardness	El. conductivity S · m / mm ²	Melting range
MPa	MPa	%	HB		° 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. For better handling of oxyd formation is recommend to use AC current type.

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
1,6 x 1000	AC/ DC (-)	I 1
2,0 x 1000	AC/ DC (-)	I 1
2,4 x 1000	AC/ DC (-)	I 1
3,2 x 1000	AC/ DC (-)	I 1