

## Classifications

EN ISO 24373	Material-No.
S Cu 6327 (CuAl8Ni2Fe2Mn2)	2.0922

## Characteristics and field of use

UTP A 3422 is used for copper-aluminium alloys with Ni and Fe addition. Weld cladding on cast iron materials and steel. Mixed joints of aluminium bronze steel. It is resistant to seawater, and cavitation resistant.

The weld metal of UTP A 3422 is resistant to seawater and cavitation. Good suitability for simultaneous stress strain caused by seawater, cavitation and erosion.

## Typical analysis in %

Mn	Ni	Cu	Al	Fe
1.8	2.5	balance	8.5	1.5

## 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 <sup>2</sup>	°C
300	650	25	160	5	1030 – 1050

## 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