UTP A 3422

TIG rod

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

Characteristics and field of use

UTP A 3422 is suitable for copper-aluminium alloys with Ni and Fe addition and for weld cladding on cast iron materials and steel as well as for mixed joints of aluminium bronze steel.

The weld metal of UTP A 3422 is resistant to seawater and corrosion and is well suited for the 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 $S \cdot m / mm^2$	Melting range
MPa	MPa	%	HB		°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. To avoid oxyd formation, UTP Flux 34 Sp needs to be deposited onto the base rods prior to the welding process.

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
2,0 x 1000	DC (-)	I 1
2,4 x 1000*	DC (-)	I 1
3,2 x 1000	DC (-)	I 1
*available on request		