

Classifications					
EN ISO 24373	AWS A5.7			Material-No.	
S Cu 1898 (CuSn1)	ER Cu			2.1006	
Characteristics and field of use					
UTP A 381 is used for oxygen free copper types according to DIN 1787 OF-Cu, SE-Cu, SW-Cu, SF-Cu. The main applicational fields are in the apparatus- and pipeline construction.					
Fluid weld pool.					
Typical analysis in %					
Si	Mn	Ni	Cu	Sn	
0,3	0,25	< 0,3	balance	0,8	
Mechanical properties of the weld metal					
Yield strength R _{P0,2}	Tensile strength R _m	Elongation A ₅	Hardness	El. conductivity S · m / mm ²	Melting range
MPa	MPa	%	HB		° C
50	200	30	approx. 60	15-20	1020-1050
Welding instruction					
Clean weld area thoroughly. For each application field the parameters must be optimized. In a wall thickness > 3 mm, preheating to maximal 600° C is necessary.					
Rod diameter x length [mm]	Current type		Shielding gas (EN ISO 14175)		
1,6 x 1000	DC (-)		I 1		
2,0 x 1000	DC (-)		I 1		
2,4 x 1000	DC (-)		I 1		
3,2 x 1000	DC (-)		I 1		