

Classifications

EN ISO 24373	AWS A5.7	Material-No.
S Cu 6560 (CuSi3Mn1)	ER CuSi-A	2.1461

Characteristics and field of use

UTP A 384 is especially suited for joints of coated steel plates according to the MIG welding for repair welding of motor vehicle bodies and plate constructions of all sorts. The alloy is also especially suited for hot galvanized and hot dip galvanized plates. Same joints on copper-silicon and copper-manganese alloys according to DIN 1766, as for example CuSi2Mn, CuSi3Mn, CuMn5, brass and red brass (tombac).

The low hardness of UTP A 384 allows a relatively easy machining of the visible weld seam in comparison to the iron base weld metal.

Typical analysis in %

Si	Mn	Cu	Sn	Fe
3.0	1.0	balance	< 0.2	< 0.3

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	$s \cdot m/mm^2$	°C
120	350	40	80	3 – 4	965 – 1035

Welding instruction

Clean weld area thoroughly. Welding parameters have to be optimised for each usage. Pay attention to a low heat input. (short arc / MIG pulsed arc)

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)	
0.8*	DC (+)	I 1	I 3
1.0	DC (+)	I 1	I 3
1.2	DC (+)	I 1	I 3
1.6*	DC (+)	I 1	I 3

*available on request