

# UTP A 3422 MR

copper alloys

## Classifications

flux coated TIG rod

DIN 1733

Material-No.

SG-CuAl8Ni2Fe2Mn2

2.0922

## Characteristics and field of use

UTP A 3422 MR TIG rods are especially designed for cladding applications on cast parts made of multicomponent aluminium bronze. The complex alloy has high resistance against erosion and cavitation pitting.

Because of the good corrosion resistance against seawater, the most common applications are in shipbuilding industry (propeller, pumps, and armatures) and seawater desalination plants.

The welding rods are provided with grooves, which are then filled with a suitable flux, so that an additional flux is not necessary and the optimum amount of flux is ensured for the processing.

## Typical analysis of rod and wire in %

Mn	Ni	Fe	Al	Cu
1.5	2.0	2.0	8.0	balance

## Mechanical properties of the weld metal

<i>Yield strength</i> $R_{p0.2}$	<i>Tensile strength</i> $R_m$	<i>Elongation</i> $A$	<i>Hardness</i> $HB$	<i>Melting range</i> $^{\circ}C$
MPa	MPa	%	HB	$^{\circ}C$
300	550	25	approx. 160	1030 – 1040

## Welding instructions

Prior to welding grind and clean the welding area. The surface should be free from any dust, oil or grease. Set the welding parameters as low as applicable in order to keep heat input low.

## Approvals

GL

## Form of delivery and recommended welding parameters

<i>Rod diameter x length [mm]</i>	<i>Current type</i>	<i>Shielding gas (EN ISO 14175)</i>
3.0 x 1000	DC (-)	I 1