UTP A 387 copper alloys

Classifications		TIG rod
EN ISO 24373	AWS A5.7	Material-No.
S Cu 7158 (CuNi30Mn1FeTi)	ER CuNi	2.0837

Characteristics and field of use

UTP A 387 is used for copper nickel alloys with up to 30 % nickel according to DIN 17664, such as CuNi20Fe (2.0878), CuNi30Fe (2.0882). Chemical industry, seawater desalination plants, ship building, offshore technique.

The weld metal of UTP A 387 is resistant to seawater and cavitation.

Typical analysis in %

C	Mn	Ni	Cu	Ti	Fe
< 0.05	0.8	30.0	balance	< 0.5	0.6

Mechanical properties of the weld metal

Yield strength $R_{p0.2}$	*Tensile strength* R_m	*Elongation* A_5	*Hardness*	*El. conductivity* $\frac{S \cdot m}{mm^2}$	*Melting range*
MPa	*MPa*	*%*	*HB*		*°C*
> 200	> 360	> 30	120	3	1180 – 1240

Welding instructions

V-butt weld with 70 ° included angle and root gap of 2 mm. Remove oxide skin to approx. 10 mm to the joint groove also on the backside of the weld.

Approvals

TÜV (No. 01625), GL

Form of delivery and recommended welding parameters

Rod diameter x length [mm]	*Current type*	*Shielding gas (EN ISO 14175)*
1.2 x 1000*	DC (–)	I 1
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

*available on request