

UTP A 3444

copper alloys

Classifications TIG rod

EN ISO 24373	AWS A5.7	Material-No.
S Cu 6328 (CuAl9Ni5Fe3Mn2)	ER CuNiAl	2.0923

Characteristics and field of use

UTP A 3444 is a copper aluminium multi bronzes with a high Ni and Fe addition. Weld cladding on cast iron materials and steel. Mixed joints with aluminium bronze steel. It is resistant to seawater and cavitation resistant.

The weld metal of UTP A 3444 is resistant to seawater and cavitation. Good suitability for simultaneous stress strain caused by seawater, cavitation and erosion.

Typical analysis of rod and wire in %

Mn	Ni	Cu	Al	Fe
1.0	4.5	balance	9.0	3.5

Mechanical properties of the weld metal

<i>Yield strength</i> $R_{p0.2}$ MPa	<i>Tensile strength</i> R_m MPa	<i>Elongation</i> A_5 %	<i>Hardness</i> HB	<i>El. conductivity</i> $\frac{S \cdot m}{mm^2}$	<i>Melting range</i> °C
400	700	15	200	4	1015 – 1045

Welding instructions

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.

Approvals

TÜV (No. 01896), 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>
2.0 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1
3.2 x 1000	DC (-)	I 1