

UTP A 34		copper alloys			
Classifications		solid wire			
EN ISO 24373	AWS A5.7	Material-No.			
S Cu 6100 (CuAl7)	ER CuAl-A 1	2.0921			
Characteristics and field of use					
UTP A 34 is used for copper aluminium alloys (aluminium bronzes) with 5 – 9 % Al, copper-zinc alloys (brass and special brass). Weld cladding on cast iron materials and steel.					
The weld deposit of UTP A 34 is resistant to corrosion and seawater and has good gliding properties metal-metal. UTP A 34 is easy weldable and obtains a clean weld surface.					
Typical analysis in %					
Mn	Ni	Cu	Al	Fe	
< 0.5	< 0.5	balance	8.0	< 0.5	
Mechanical properties of the weld metal					
<i>Yield strength $R_{p0.2}$</i>	<i>Tensile strength R_m</i>	<i>Elongation A_5</i>	<i>Hardness</i>	<i>El. conductivity</i>	<i>Melting range</i>
MPa	MPa	%	HB	s-m / mm ²	°C
180	400	40	120	8	1030 – 1040
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.					
Approvals					
GL					
Form of delivery and recommended welding parameters					
<i>Wire diameter [mm]</i>	<i>Current type</i>	<i>Shielding gas (EN ISO 14175)</i>			
0.8*	DC (+)	I 1			
1.0	DC (+)	I 1			
1.2	DC (+)	I 1			
1.6	DC (+)	I 1			
*available on request					