# UTP A 3422 copper alloys

| Classifications | solid wire |
|---|---|
| EN ISO 24373 | Material-No. |
| S Cu 6327 (CuAl8Ni2Fe2Mn2) | 2.0922 |

## Characteristics and field of use

UTP A 3422 is used for copper-aluminium alloys with Ni and Fe addition. Weld cladding on cast iron materials and steel. Mixed joints of aluminium bronze steel. It is resistant to seawater, and cavitation resistant.

The weld metal of UTP A 3422 is resistant to seawater and cavitation. Good suitability for simultaneous stress strain caused by seawater, cavitation and erosion.

## Typical analysis in %

| Mn | Ni | Cu | Al | Fe |
|---|---|---|---|---|
| 1.8 | 2.5 | balance | 8.5 | 1.5 |

## 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·m / mm²* | *°C* |
| 300 | 650 | 25 | 160 | 5 | 1030 – 1050 |

## 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

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