UTP A 3444

copper alloys

Classifications

solid wire

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 in %

Mn	Ni	Cu	Al	Fe
1.0	4.5	balance	9.0	3.5

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*
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.

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