

<b>Classifications</b>				
DIN 1733		Material-No.		
SG-CuAl8Ni2		2.0922		
<b>Characteristics and field of use</b>				
<p>UTP A 3422 MR TIG rods are especially designed for cladding applications on cast parts made of multicomponent aluminium bronze. The complex alloy has high resistance against erosion and cavitation pitting.</p> <p>Because of the good corrosion resistance against seawater, the most common applications are in shipbuilding industry (propeller, pumps, and armatures) and seawater desalination plants.</p> <p>The welding rods are provided with grooves, which are then filled with a suitable flux, so that an additional flux is not necessary and the optimum amount of flux is ensured for the processing.</p>				
<b>Typical analysis in %</b>				
Mn	Ni	Fe	Al	Cu
1,5	2,0	2,0	8,0	balance
<b>Mechanical properties of the weld metal</b>				
Yield strength $R_{P0,2}$	Tensile strength $R_m$	Elongation A	Hardness	Melting range
MPa	MPa	%	HB	° C
300	550	25	approx. 160	1030-1040
<b>Welding instruction</b>				
<p>Prior to welding grind and clean the welding area. The surface should be free from any dust, oil or grease. Set the welding parameters as low as applicable in order to keep heat input low.</p>				
<b>Approvals</b>				
GL				
Rod diameter x length [mm]	Current type		Shielding gas (EN ISO 14175)	
3,0 x 1000	DC (-)		I 1	