

Classifications					
EN ISO 24373			Material-No.		
S Cu 6327 (CuAl8Ni2Fe2Mn2)			2.0922		
Characteristics and field of use					
<p>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.</p> <p>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.</p>					
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	$S \cdot m/mm^2$	$^{\circ}C$
300	650	25	160	5	1030 – 1050
Welding instruction					
<p>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.</p>					
Approvals					
GL					
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		