

Classifications					
EN ISO 24373		AWS A5.7		Material-No.	
S Cu 6100 (CuAl7)		ER CuAl-A 1		2.0921	
Characteristics and field of use					
<p>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.</p> <p>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.</p>					
Typical analysis in %					
Mn	Ni	Cu	Al	Fe	
< 0.5	< 0.5	balance	8.0	< 0.5	
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	$s \cdot m/mm^2$	°C
180	400	40	120	8	1030 – 1040
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)		
0.8*	DC (+)		I 1		
1.0	DC (+)		I 1		
1.2	DC (+)		I 1		
1.6	DC (+)		I 1		
*available on request					