

## Classifications

EN ISO 24373	AWS A5.7	Material-No.
S Cu 1898 (CuSn1)	ER Cu	2.1006

## Characteristics and field of use

UTP A 381 is used for oxygen free copper types according to DIN 1787 OF-Cu, SE-Cu, SW-Cu, SF-Cu. The main applicational fields are in the apparatus- and pipeline construction.

Fluid weld pool.

## Typical analysis in %

Si	Mn	Ni	Cu	Sn
0.3	0.25	< 0.3	balance	0.8

## 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
50	200	30	approx. 60	15 – 20	1020 – 1050

## Welding instruction

Clean weld area thoroughly. For each application field the parameters must be optimized. In a wall thickness > 3 mm, preheating to maximal 600 °C is necessary.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)	
1.0*	DC (+)	I 1	I 3
1.2	DC (+)	I 1	I 3
1.6	DC (+)	I 1	I 3

\*available on request