UTP 32

basic-coated tin-bronze stick electrode

Classifications		
DIN 1733	AWS A5.6	Material-No.
EL-CuSn7	E CuSn-C (mod.)	2.1025

Characteristics and field of use

UTP 32 is a basic-coated tin-bronze stick electrode for joining and surfacing on copper tin alloys with 6 – 8 % Sn, copper-tin alloys and for weld claddings on cast iron materials and on steel.

UTP 320 is easy weldable and the slag removal is also easy. The corrosion resistance is corresponding to identical or similar base metals. Seawater resistant. Very good gliding properties.

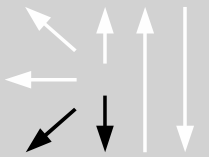
Typical analysis in %	
Cu	SN
balance	7,0

Mechanical properties of the weld metal				
Yield strength $R_{P0,2}$	Tensile strength R_m	Hardness	Elongation conductivity	Melting range
MPa	MPa	HD	S x m / mm^2	°C
approx. 300	> 30	approx. 100	approx. 7	910 - 1040

Welding instruction

Clean welding area thoroughly. Ignite stick electrode inclined with scratch start. For wall thickness of > 8 mm a preheating of 100 – 250° C is necessary. Hold stick electrode vertically and weave slightly. Use only dry stick electrodes. Redrying 2 – 3h at 150° C.

Welding positions



Current type DC (+)

Recommended welding parameters			
Electrodes Ø x L [mm]	2,5 x 300	3,2 x 350	4,0 x 350
Amperage [A]	60 – 80	80 – 100	100 – 120