

UTP 47

Standard :

Material-No. : 3.0286
 DIN 1732 : EL-A199,8
 AWS A5.3 : ~ E 1100

Pure aluminium stick electrode

Application field

UTP 47 is a pure aluminium stick electrode with a special coating for joining and surfacing

Welding properties

UTP 47 is good weldable on sheets with > 2 mm wall-thickness. The soft flow produces a flat, finely rippled weld seam. Good slag removal.

Mechanical properties of the weld metal

| Yield strength Rp0,2 MPa | Tensile strength Rm MPa | Elongation A5 % |
|--------------------------------|-------------------------------|-----------------------|
| > 40 | 80 | 30 |

Weld metal analysis in %

| Al | Others |
|------|------------|
| 99,8 | 0,2 (max.) |

Welding instruction

Weld stick electrode in the vertical position with a short arc. Preheat bigger work pieces with wall thicknesses > 6 mm to 100 - 250°C in order to contain a good fusion with the base metal. Raised weld seams indicate to low preheating temperatures. Re-drying: 1 - 1,5 h at 100°C.

Current type = +

Welding positions


Availability / Current adjustments

| Stick electrodes | Ø mm x L | 2,5* x 355 | 3,2* x 355 |
|------------------|----------|------------|------------|
| Amperage | A | 50 - 70 | 80 - 100 |

* available on request

Available in 2,0 kg boxes