

## Classifications

<b>AWS A5.6 / SFA-5.6</b>	<b>Material-No.</b>	<b>EN ISO 17777</b>
E CuSn-C (mod.)	2.1025	E Cu 5180B (CuSn7)

## Characteristics and typical fields of application

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

	Sn	Cu
wt.-%	7.0	bal.

## Mechanical properties of all-weld metal - typical values (min. values)

Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Hardness	Electrical conductivity	Melting range
MPa	%	HB	S x m / mm <sup>2</sup>	°C
300	25	ca. 100	ca. 7	910 - 1040

## Operating data

	<b>Polarity</b>	DC +	<b>Dimension mm</b>	<b>Current A</b>
			2.5 x 350	60 – 80
			3.2 x 350	80 – 100
			4.0 x 450	100 – 120

## Welding instructions

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.

## Approvals

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