UTP 34 N

Basic coated complex aluminiumbronze stick electrode

Classifications

AWS A5.13 / SFA-5.13	DIN 8555	EN ISO 17777
E CuMnNiAl (mod.)	E 31-UM-200-CN	E Cu 6338 (CuMn13Al7Fe3Ni2)

Characteristics and typical fields of application

UTP 34 N is suitable for joinings and surfacings on copper-aluminium alloys, specially with high Mn-content as well as for claddings on cast iron materials and steel. Main application fields are in the shipbuildung (propeller, pumps, armatures) and in the chemical industry. The good friction coefficient permits claddings on shafts, bearings, stamps, drawing tools and all kind of gliding surface. UTP 34 N has excellent welding properties, spatterfree welding, good slag removal. The weld deposit has high mechanical values, a good corrosion resistance in oxidizing media, best gliding properties and a very good machinability. Crack resistant and pore-free.

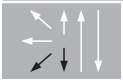
Typical analysis

	Mn	Ni	Fe	Cu	Al
wt.-%	13.0	2.5	2.5	bal.	7.0

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

Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Hardness
MPa	MPa	%	HB
400	650	15	220

Operating data



Polarity	DC +

Dimension mm	Current A
2.5 x 350	50 – 70
3.2 × 350	70 – 90
4.0 x 350	90 – 110

Welding instructions

Clean welding area thoroughly. Preheating of thick-walled parts to 150 – 250° C. Hold electrode as vertically as possible and weld with slight weaving. Weld with dry stick electrodes only! Redrying: 2 – 3 h at 150° C.

Approvals

DB (62.138.03)