

Classifications		
DIN 1733	AWS A5.6	Material-No.
EI-CuAl9	E CuAl-A2	2.0926

**Characteristics and field of use**

UTP 34 is a basic-coated aluminium-bronze stick electrode with 8% Al for joining and surfacing on aluminium-bronzes with 5 - 9% Al and copper-tin alloys as well as for weld claddings on cast iron materials and steel.

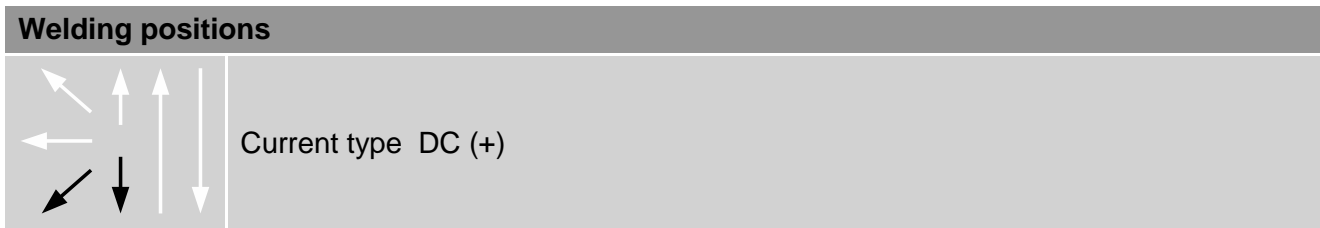
UTP 34 is easily weldable and is characterized by good slag removal. The corrosion resistance is corresponding to identical or similar base metals. Seawater resistant. Very good gliding properties.

Typical analysis in %			
Si	Cu	Al	Fe
< 0.7	balance	8.0	1.0

Mechanical properties of the weld metal					
Yield strength $R_{p0,2}$	Tensile strength $R_m$	Elongation $A_5$	Hardness	El. conductivity $S \cdot m / mm^2$	Melting range
MPa	MPa	%	HB		°C
approx. 200	approx. 450	> 20	approx. 130	approx. 6	1030 – 1040

**Welding instruction**

Clean welding area thoroughly. 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. Re-drying 2 – 3h at 150°C.



Recommended welding parameters	
Electrodes $\varnothing \times L$ [mm]	4.0 x 350
Amperage [A]	100 – 120