

Classifications

DIN 1733	Material-No.
EL-CuAl9Ni2Fe	2.0930

Characteristics and field of use

Basic coated multi-alloyed aluminium-bronze stick electrode for joining and surfacing of similar aluminium-bronzes as well as for mixed joints with low alloyed steel. It is mainly used for shipbuilding and plant engineering.

UTP 3422 has a good weldability and good resistance against cavitation. The weld deposit is resistant to seawater. Good machinable.

Typical analysis in %

Si	Mn	Ni	Cu	Al	Fe
0,6	1,6	2,7	Rest	8,3	1,7

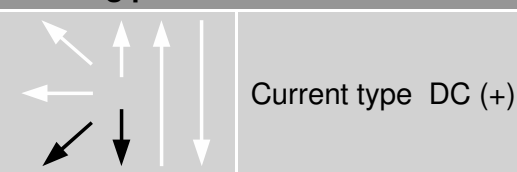
Mechanical properties of the weld metal

Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A_5	Hardness	Melting range
MPa	MPa	%	HB	°C
400	650	8	ca. 180	1030 – 1050

Welding instruction

Clean weld area thoroughly. In a wall thickness above 5 mm grooving with V-seam (90°) is necessary. In a wall thickness above 10 mm preheat to 150-200°C. Vertical guidance of stick electrode in high temperatures in order to avoid overheating. Use dry stick electrodes only. Redrying of stick electrodes 2-3 h at 150 °C.

Welding positions



Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	3,2 x 350
Amperage [A]	90 – 110