

DIN 1733	Material-No.
EL-CuNi10Mn	2.0877

Characteristics and field of use

UTP 389 is a basic-coated copper-nickel stick electrode for joining and surfacing of alloys of similar nature with a nickel content up to 10%.
UTP 389 is weldable in all positions except vertical downwards. The weld deposit is resistant to seawater.

Typical analysis in %

C	Si	Mn	Ni	Cu	Ti	Fe
< 0.03	< 0.4	1.5	10.0	balance	< 0.5	1.5

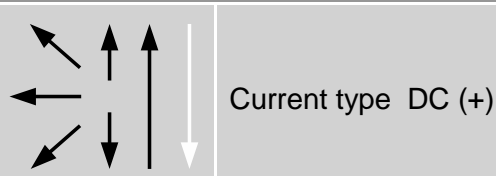
Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A_5
MPa	MPa	%
240	320	25

Welding instruction

Use a single V weld with an opening angle of at least 70° and a root gap of approximately 2 mm. Remove oxide skin up to approx. 10 mm next to the welding area, repeat the same on the backside. Welding area must be metallic bright and thoroughly degreased. Fuse the arc strike point again by bringing the stick electrode back, in order to obtain a good bond. Keep the arc short.

For cladding welds on carbon or fine grained steels an interpass layer with UTP 80 M is necessary.

Welding positions



Approvals

TÜV (No. 04185)

Electrodes $\varnothing \times L$ [mm]	2,5 x 300*	3,2 x 350
Amperage [A]	50 - 70	80 - 100

* available on request