UTP 34 N

Basic coated complex aluminium-bronze stick electrode with 13 % Mn for wear and corrosion resistant surfacings on dies

Standards :

DIN 8555	:	E 31-UM-200-CN
EN 14700	:	E Cu1
AWS A5.6	:	E CuMnNiAl

Application field

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.

Welding properties and special properties of the weld deposit

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.

Hardness of the pure weld deposit approx. 200 HB

Mechanical properties of the weld metal

Yield strength $R_{p0,2}$ MPa	Tensile strength R_m MPa	Elongation A %	Hardness HB
> 400	> 650	> 25	approx. 220

Weld metal analysis in %

Mn	Ni	Cu	Al	Fe
13,0	2,5	balance	7,0	2,5

Welding instruction

Clean welding area thoroughly. Pre-heating of thick-walled parts to 150 - 250° C. Hold electode as vertically as possible and weld with slight weaving. Weld with dry stick electrodes only!
Re-drying: 2 - 3 h at 150° C.

Current type DC (+)

Welding positions



PA PB

Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 350	3,2 x 350	4,0 x 350
Amperage	A	50 – 70	70 – 90	90 – 110

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