UTP A 32

CuSn-alloyed inert gas welding wire with 7 % Sn

Standards :

Material-No.	:	2.1022
EN ISO 24373	:	S Cu 5180 A (CuSn 6 P)
AWS A5.7	:	ER CuSn-A (mod.)

Application field

UTP A 32 is used for copper and tin alloys with 6 - 8 % Sn, according to DIN 17662, copper-zinc alloys, copper-tin-zinc-lead alloys. Weld cladding on cast iron materials and steel. It has good gliding properties.

Welding properties

UTP A 32 is a corrosion and overheating resistant alloy. Very good weldability.

Mechanical properties of the weld metal

Yield strength $R_{p0,2}$ MPa	Tensile strength R_m MPa	Elongation A_5 %	Hardness HB	El. conductivity $\frac{S \cdot m}{mm^2}$	Melting range ° C
150	300	20	80	7 - 9	910 - 1040

Weld metal analysis in %

Sn	P	Cu	Fe
7,0	< 0,3	balance	< 0,1

Welding instruction

Clean welding area thoroughly and weld with low amperage. In wall thicknesses above 10 mm preheat to 100 - 250 °C.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175		Availability	
				Spools	Rods
		I 1	I 3	EN ISO 544	EN ISO 544
1,0	DC (+)	x	x	x	
1,2	DC (+)	x	x	x	
1,6	DC (+)	x	x	x	
1,6	DC (-)	x			x
2,0	DC (-)	x			x
2,4	DC (-)	x			x
3,2	DC (-)	x			x

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