

Classifications

DIN 1733	AWS A5.6	Material-No.
EL-CuNi30Mn	E CuNi	2.0837

Characteristics and field of use

The copper-nickel base stick electrode UTP 387 is used for joining and surfacing alloys of similar compositions with up to 30 % nickel, as well as non-ferrous alloys and steels of different nature. The seawater-resistant weld metal enables this special stick electrode to be employed in ship-building, oil refineries, the food industry and in the engineering of corrosion-proof vessels and equipment generally.

UTP 387 can be welded in all positions, except vertical-down, seawater resistant.

Typical analysis in %

C	Si	Mn	Ni	Cu	Fe
0,03	0,3	1,2	30,0	balance	0,6

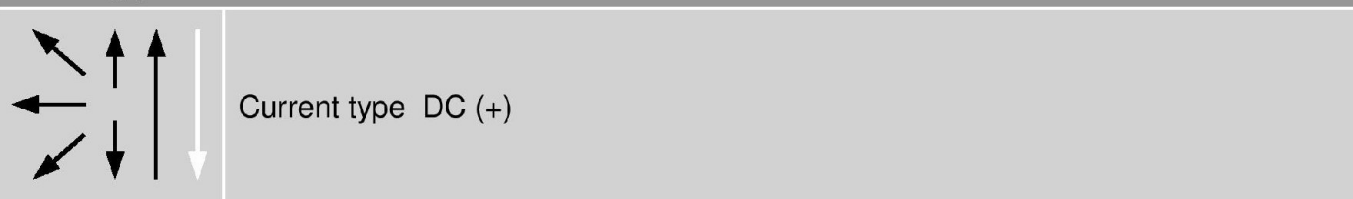
Mechanical properties of the weld metal

Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A	Impact strength K_v
MPa	MPa	%	J
> 240	> 390	> 30	> 80

Welding instruction

Groove out a V seam with min. 70° C and provide a root gap of 2 mm. Remove the oxide skin about 10 mm beside the joint, on the reverse side too. The weld zone must be bare and properly degreased. Fuse the arc strike point again by bringing the stick electrode back, in order to obtain a good bond. Keep the arc short.

Welding positions



Approvals

TÜV (No. 01626), GL

Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2,5 x300*	3,2 x 350	4,0 x 350*
Amperage [A]	60 – 80	80 – 105	110 – 130

*available on request

