

UTP A 320

Standards :

Material-No. : 2.1056
 EN ISO 24373 : S Cu 5410 (CuSn12P)

**CuSn-alloyed inert gas welding wire
 with 12 % Sn**

Application field

UTP A 320 is used copper-tin alloys with more than 8 % Sn, copper -zinc alloys, copper-tin-zinc-lead alloys. Weld cladding on cast iron materials and steel. Resistant to seawater.

Properties of the weld metal

The corrosion resistance of **UTP A 320** corresponds to the similar alloying base metals. Good sliding properties and machinability.

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
140	300	25	150	7 - 9	825 - 990

Weld metal analysis in %

Sn	P	Cu	Fe
12,0	< 0,35	balance	< 0,1

Welding instruction

Clean weld area thoroughly. Preheating in wall thicknesses > 8 mm to 100 - 250°C is necessary.

Welding procedure and availability

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

