

## Classifications

EN ISO 24373	AWS A5.7	Material-No.
S Cu 7158 (CuNi30Mn1FeTi)	ER CuNi	2.0837

## Characteristics and field of use

UTP A 387 is used for copper nickel alloys with up to 30 % nickel according to DIN 17664, such as CuNi20Fe (2.0878), CuNi30Fe (2.0882). Chemical industry, seawater desalination plants, ship building, offshore technique.

The weld metal of UTP A 387 is resistant to seawater and cavitation.

## Typical analysis in %

C	Mn	Ni	Cu	Ti	Fe
< 0,05	0,8	30,0	balance	< 0,5	0,6

## Mechanical properties of the weld metal

Yield strength R <sub>P0,2</sub>	Tensile strength R <sub>m</sub>	Elongation A <sub>5</sub>	Hardness	El. conductivity S · m / mm <sup>2</sup>	Melting range
MPa	MPa	%	HB		° C
> 200	> 360	> 30	120	3	1180-1240

## Welding instruction

V-butt weld with 70° included angle and root gap of 2 mm. Remove oxide skin to approx. 10 mm to the joint groove also on the backside of the weld.

## Approvals

TÜV (No. 01625), GL

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
1,2 x 1000*	DC (-)	I 1
1,6 x 1000	DC (-)	I 1
2,0 x 1000	DC (-)	I 1
2,4 x 1000	DC (-)	I 1
3,2 x 1000	DC (-)	I 1

\*available on request

