UTP 32

basic-coated tin-bronze stick electrode

Classifications		
DIN 1733	AWS A5.6	Material-No.
EL-CuSn7	E CuSn-C (mod.)	2.1025

Characteristics and field of use

UTP 32 is a basic-coated tin-bronze stick electrode for joining and surfacing on copper tin alloys with 6 – 8 % Sn, copper-tin alloys and for weld claddings on cast iron materials and on steel.

UTP 32 is easily weldable; good slag removal. The corrosion-resistance is corresponding to identical or similar base metals. Good gliding properties.

Typical analysis in %	
Cu	Sn
balance	7.0

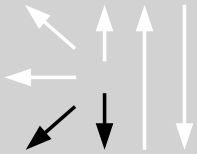
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Hardness	Electrical conductivity	Melting range
MPa	MPa	HB	S x m / mm^2	°C
approx. 300	> 30	approx. 100	approx. 7	910 - 1040

Welding instructions

Clean welding area thoroughly. Ignite stick electrode inclined with scratch start. For wall thickness of > 8 mm a preheating of 100 – 250° C is necessary. Hold stick electrode vertically and weave slightly. Use only dry stick electrodes. Re-drying 2 – 3h at 150° C.

Welding positions



Current type DC (+)

Recommended welding parameters			
Electrodes Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 350
Amperage [A]	60 – 80	80 – 100	100 – 120