

## Classifications

EN ISO 24373	AWS A5.7	Material-No.
S Cu 1898 (CuSn1)	ER Cu	2.1006

## Characteristics and field of use

UTP A 381 is used for oxygen free copper types according to DIN 1787 OF-Cu, SE-Cu, SW-Cu, SF-Cu. The main applicational fields are in the apparatus- and pipeline construction.

Fluid weld pool.

## Typical analysis in %

Si	Mn	Ni	Cu	Sn
0,3	0,25	< 0,3	balance	0,8

## Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength $R_m$	Elongation $A_5$	Hardness	El. conductivity $S \cdot m / mm^2$	Melting range
MPa	MPa	%	HB		° C
50	200	30	approx. 60	15-20	1020-1050

## Welding instruction

Clean weld area thoroughly. For each application field the parameters must be optimized. In a wall thickness > 3 mm, preheating to maximal 600° C is necessary.

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
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