UTP A 389

solid wire

Classifications	
EN ISO 24373	Material-No.
S Cu 7061 (CuNi10)	2.0873

Characteristics and field of use

UTP A 389 is used for copper nickel alloys with 5 – 10 % nickel according to DIN 17664, for example CuNi5Fe (2.0862), CuNi10Fe (2.0872). Chemical plant industry, seawater desalination plants, ship building, offshore technique.

The weld deposit of UTP A 389 is highly corrosion resistant, for example against non oxidizing, organic acids and salt solutions and seawater.

Typical analysis in %

C	Mn	Ni	Cu	Ti	Fe
< 0.05	0.8	10.0	balance	< 0.5	1.35

Mechanical properties of the weld metal

Yield strength $R_{P0.2}$	Tensile strength R_m	Elongation A_5	Hardness	El. conduc-tivity	Melting range
MPa	MPa	%	HB	s·m/mm^2	°C
> 150	> 300	> 30	100	5	1100 – 1145

Welding instruction

Degrease and clean weld area to metallic bright. Remove oxide skin to 10 mm next to welding groove, also on the backside of the weld. Pay attention to low energy input. The interpass temperature should not exceed 120 °C. Preheating and postweld heat treatment is not intended.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)	
1.0*	DC (+)	I 1	I 3
1.2	DC (+)	I 1	I 3
*available on request			