

Classifications basic-coated copper-nickel stick electrode 70 / 30

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|-------------|----------|--------------|
| DIN 1733 | AWS A5.6 | Material-No. |
| EL-CuNi30Mn | E CuNi | 2.0837 |

Characteristics and field of use

The copper-nickel base stick electrode UTP 387 is used for joining and surfacing alloys of similar com-positions with up to 30% nickel, as well as non-ferrous alloys and steels of different nature. The seawater-resistant weld metal enables this special stick electrode to be employed in ship-building, oil refineries, the food industry and in the engineering of corrosion-proof vessels and equipment generally.

UTP 387 can be welded in all positions, except vertical-down, seawater resistant.

Typical analysis in %

| | | | | | |
|------|-----|-----|------|---------|-----|
| C | Si | Mn | Ni | Cu | Fe |
| 0.03 | 0.3 | 1.2 | 30.0 | balance | 0.6 |

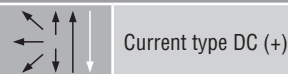
Mechanical properties of the weld metal

| Yield strength $R_{p0.2}$ | Tensile strength R_m | Elongation A | Impact strength K_V |
|---------------------------|------------------------|----------------|-----------------------|
| MPa | MPa | % | J |
| > 240 | > 390 | > 30 | > 80 |

Welding instructions

Groove out a V seam with min. 70 °C and provide a root gap of 2 mm. Remove the oxide skin about 10 mm beside the joint, on the reverse side too. The weld zone must be bare and properly de-greased. Fuse the arc strike point again by bringing the stick electrode back, in order to obtain a good bond. Keep the arc short.

Welding positions



Approvals

TÜV (No. 01626), GL

Form of delivery and recommended welding parameters

| | | | |
|--|-----------|-----------|------------|
| Electrodes $\varnothing \times L$ [mm] | 2.5 x300* | 3.2 x 350 | 4.0 x 350* |
| Amperage [A] | 60 – 80 | 80 – 105 | 110 – 130 |

*available on request