Standards :

EN 1044	:	CU 304
DIN 8513	:	L-CuZn39Sn
EN ISO 3677	:	BCu60Zn(Sn)870-900

UTP 1
UTP 1 M
UTP 1 MR

Special brass brazing alloy, mainly for hot-dip galvanized pipes

Application field

The special alloy **UTP 1 / M / MR** is suited for joints and surfacings on steel, copper, brass, bronzes and grey cast iron. It allows for even coloured pore-free joints of brass. It is ideally suited for joining many non-ferrous metals, pipe constructions (tube structures), sanitary installations, locksmith work and repair work. Working temperature up to 300°C

Heating sources

Acetylene torch, HF-induction

Technical data

Working temperature ° C	Tensile strength R_m MPa
890	420 (St 50)

Weld metal analysis in %

Si	Cu	Sn	Zn
0,35	60,5	0,5	balance

Instructions

Clean solder joint thoroughly and apply flux. Large weldments must be preheated right through and over a wide area. Melt off drog wise upon reaching working temperature.

Flame adjustment

For brass, bronze and galvanized steels	slight oxygen excess
For copper and steels	neutral (neither gas nor oxygen excess)

Availability

UTP 1	Rods	Ø mm x 500 mm	1,5*	2,0	3,0
UTP 1 M	Rods	Ø mm x 500 mm	-	2,0	3,0
UTP 1 MR	Rods	Ø mm x 500 mm	-	-	3,2

* available on request

Special types available on request

Fluxes

UTP Flux HLS	Universal flux in paste form
UTP Flux HLP	Universal flux in powder form
UTP Flux HLS-B	Special flux in paste form for hot-galvanized work pieces (weld brazing)

Approvals

GL

M	=	flux coated rod
MR	=	flux coated rod with a minimum amount of flux
MD	=	flux coated rod with a minimum amount of flux