

**Standards :**

EN 1044 : CU 305  
 DIN 8513 : L-CuNi10Zn42  
 EN ISO 3677 : BCu48ZnNi890-920

# UTP 2

## UTP 2 M

**Ni-containing brass type special brazing alloy for high strength-joinings**

**Application field**

**UTP 2 / M** is a brazing alloy for build-ups on steel, grey cast iron and malleable cast iron against gliding wear, wear and corrosion resistant.

**Heating sources**

Acetylene torch, HF-induction

**Technical data**

Working temperature ° C	Tensile strength R <sub>m</sub> MPa
910	690 (S 355)

**Weld metal analysis in %**

Si	Ni	Cu	Zn
0,2	10,0	48,0	balance

**Instructions**

Clean solder joint thoroughly. Chamfer the edges. Coat rods and brazing area with UTP Flux HLS, preheat the whole work piece right through over a wide area. Set tip of rod onto joint. Melt off drops and spread out with flame. Due to its thin flowing and if used sparingly finishing is not necessary. It is very important not to overheat, in order to achieve the optimal strength values.

**Flame adjustments**

Neutral (neither gas nor oxygen excess)

**Availability**

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

\* 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

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