

UTP A 38

Standards :

Material-No. : 2.1211
 EN ISO 24373 : S Cu 1897 (CuAgI)
 AWS A5.7 : ER Cu

**CuAg alloyed inert gas welding wire
 for oxygen free copper types**

Application field

UTP A 38 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 equipment (machine) construction, pipe lines, conductor rails.

Welding properties

Viscous weld puddle, fine grained structure, high electrical conductivity

Mechanical properties of the weld metal

Yield strength R _{p0,2} MPa	Tensile strength R _m MPa	Elongation A ₅ %	Hardness HB	El. conductivity $\frac{S \cdot m}{mm^2}$	Melting range ° C
80	200	20	60	30 - 45	1020 - 1060

Weld metal analysis in %

Mn	Ni	Cu	Ag
< 0,2	< 0,3	balance	1,0

Welding instruction

Clean welding area thoroughly. For wall thickness of > 3 mm a preheating is necessary (max 600°C).

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175		Availability	
		I 1	I 3	Spools EN ISO 544	Rods EN ISO 544
1,0 *	DC (+)	x	x	x	
1,2 *	DC (+)	x	x	x	
1,6 *	DC (+)	x	x	x	
1,6	DC (-)	x			x
2,0	DC (-)	x			x
2,4	DC (-)	x			x
3,2	DC (-)	x			x

* available on request