

UTP A 3127 LC

Fully austenitic rods and wires for corrosion resistant steels

Standards :

Material-No. : 1.4563
 EN ISO 14343-A : W/G 27 31 4 Cu L
 AWS A5.9 : ER 383

Application field

UTP A 3127 LC is suited for joining and surfacing base materials of the same and similar natures, e. g.

1.4500	G- X 7	NiCrMoCuNb	25 20
1.4505	X 5	NiCrMoCuNb	20 18
1.4506	X 5	NiCrMoCuTi	20 18
1.4539	X 2	NiCrMoCu	25 20 5
1.4563	X 1	NiCrMoCu	31 37
2.4858		NiCr21Mo	

Properties of the weld metal

UTP A 3127 LC distinguishes itself by its high resistance against phosphoric acid and organic acids. Due to its Mo- and Cu-content it shows extremely low corrosion rates, particularly when used in sulphuric acid.

Resistant against stress corrosion cracking, crevice corrosion and pitting in media containing chloride ions.

Mechanical properties of the weld metal

Yield strength R _{p0,2} MPa	Tensile strength R _m MPa	Elongation A %	Impact strength K _v Joule
> 350	> 540	> 30	> 80

Welding instruction

The welding area has to be free from impurities (oil, paint, markings). Minimize heat input. The interpass temperature should not exceed 150 °C.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175		Availability	
		I 1	M 12	Spools EN ISO 544	Rods EN ISO 544
1,2	DC (+)		x	x	
2,0	DC (-)	x			x
2,4	DC (-)	x			x

Approvals

TÜV (No. 06609)

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