

Classifications		
EN ISO 24373	AWS A5.7	Material-No.
S Cu 6328 (CuAl9Ni5Fe3Mn2)	ER CuNiAl	2.0923

Characteristics and field of use
<p>UTP A 3444 is a copper aluminium multi bronzes with a high Ni and Fe addition. Weld cladding on cast iron materials and steel. Mixed joints with aluminium bronze steel. It is resistant to seawater and cavitation resistant.</p> <p>The weld metal of UTP A 3444 is resistant to seawater and cavitation. Good suitability for simultaneous stress strain caused by seawater, cavitation and erosion.</p>

Typical analysis in %				
Mn	Ni	Cu	Al	Fe
1.0	4.5	balance	9.0	3.5

Mechanical properties of the weld metal					
Yield strength $R_{P0.2}$	Tensile strength $R_m$	Elongation $A_5$	Hardness	El. conductivity	Melting range
MPa	MPa	%	HB	$s \cdot m/mm^2$	°C
400	700	15	200	4	1015 – 1045

Welding instruction
The weld seam area has to be machined to a metallic bright by grinding, sand blasting or pickling in order to avoid crack formation or the development of pores.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
1.0	DC (+)	I 1
1.2	DC (+)	I 1
1.6	DC (+)	I 1