UTP 387

Basic coated copper-nickel stick electrode 70/30

Classifications

AWS A5.6 / SFA-5.6	Material-No.	EN ISO 17777
E CuNi	2.0837	E Cu 7158 (CuNi30Mn2FeTi)

Characteristics and typical fields of application

The copper-nickel base stick electrode UTP 387 is used for joining and surfacing alloys of similar compositions with up to 30 % nickel, as well as non-ferrous alloys and steels of different nature. The seawater-resistant weld metal enables this special stick electrode to be employed in shipbuilding, oil refineries, the food industry and in the engineering of corrosion-proof vessels and equipment generally. UTP 387 can be welded in all positions, except vertical-down, seawater resistant.

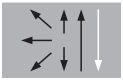
Typical analysis

	C	Si	Mn	Ni	Fe	Cu
wt.-%	0.03	0.3	1.2	30.0	0.6	bal.

Mechanical properties of all-weld metal - typical values (min. values)

Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact energy ISO-V KV J
MPa	MPa	%	
>240	>390	>30	>80

Operating data



Polarity	DC +
Redrying	1-2h / 300 °C

Dimension mm	Current A
2.5 × 300 *	60 – 80
3.2 × 350	80 – 105
4.0 × 350 *	110 – 130

*available on request

Welding instructions

Groove out a V seam with min. 70° C and provide a root gap of 2 mm. Remove the oxide skin about 10 mm beside the joint, on the reverse side too. The weld zone must be bare and properly degreased. Fuse the arc strike point again by bringing the stick electrode back, in order to obtain a good bond. Keep the arc short.

Approvals

TÜV (Nr. 01626), DNV