UTP 39

Basic-coated pure copper stick electrode

Classifications		
DIN 1733	AWS A5.6	Material-No.
EL-CuMn2	ECu (mod.)	2.1363

Characteristics and field of use

The pure copper stick electrode is suitable for joining and surfacing of all commercial pure, oxygen-free copper grades acc. to DIN 1976, such as:

Material.no.	Short mark
CW008A	Cu-OF
CW021A	Cu-HCP
CW023A	Cu-DLP
CR024A	Cu-DHP

Properties of the weld metal

UTP 39 shows a pore-free, well-deoxidized and crack-proof weld metal. Its corrosion resistance is equal to commercial copper grades.

Typical analysis in %

Cu	Mn
> 97	1.5

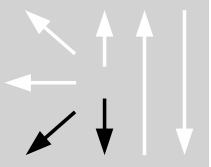
Mechanical properties of the weld metal

Yield strength $R_{p0,2}$	Hardness	Elongation A5	Electrical conductivity	Melting range
MPa	HB	%	S x m / mm^2	°C
> 200	approx. 60	> 35	approx. 20	1000 - 1050

Welding instruction

Clean welding zone thoroughly. Pre-heating of copper to 400-600°C depending on wall thickness, maintain the temperature during the welding process. Keep the arc short with steep (vertical up) stick electrode guidance. Choose the biggest possible diameter of stick electrode. Use dry stick electrodes only. If necessary, re-drying for 2-3 hours at 150°C.

Welding positions



Current type DC (+)

Approvals

DB (No. 63.138.02)

Recommended welding parameters

Electrodes Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 450
Amperage [A]	60 – 90	80 – 100	110 - 130

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.