

## UTP 47

**Standard :**  
 Material-No. : 3.0286  
 DIN 1732 : EL-AI99,8  
 AWS A5.3 : ~ E 1100

**Pure aluminium stick electrode**

### Application field

UTP 47 is a pure aluminium stick electrode with a special coating for joining and surfacing

### Welding properties

UTP 47 is good weldable on sheets with > 2 mm wall-thickness. The soft flow produces a flat, finely rippled weld seam. Good slag removal.

### Mechanical properties of the weld metal

| Yield strength<br>Rp0,2<br>MPa | Tensile strength<br>Rm<br>MPa | Elongation<br>A5<br>% |
|--------------------------------|-------------------------------|-----------------------|
| > 40                           | 80                            | 30                    |

### Weld metal analysis in %

| Al   | Others     |
|------|------------|
| 99,8 | 0,2 (max.) |

### Welding instruction

Weld stick electrode in the vertical position with a short arc. Preheat bigger work pieces with wall thicknesses > 6 mm to 100 - 250°C in order to contain a good fusion with the base metal. Raised weld seams indicate to low preheating temperatures. Re-drying: 1 - 1,5 h at 100°C.

Current type  = +

Welding positions



### Availability / Current adjustments

| Stick electrodes | Ø mm x L | 2,5* x 355 | 3,2* x 355 |
|------------------|----------|------------|------------|
| Amperage         | A        | 50 - 70    | 80 - 100   |

\* available on request

Available in 2,0 kg boxes