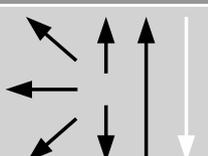


Standards							
Material-no.	EN ISO 3581-A			AWS A5.4			
~ 1.4563	E 27 31 4 Cu LR			E 383-17			
Application field							
UTP 3127 LC is suited for joining and surfacing of base materials of the same or similar nature:							
1.4500	1.4505	1.4506	1.4539	1.4563			
G-X7 NiCrMoCuNb 2520	X5 NiCrMoCuNb 20 18	X5 NiCrMoCuTi 20 18	X2 NiCrMoCu 25 20 5	X1 NiCrMoCu 31 27			
Like the base material 1.4563 the alloy distinguishes itself by high resistance against phosphoric acid and organic acids. Due to the addition of Cu besides Mo it shows extremely low corrosion rates, particularly when used in sulphuric acid. Due to the high Mo-content of more than 3.0% in combination with approx. 27% Cr, 3127 LC shows excellent resistance against stress corrosion cracking, crevice corrosion and pitting in media containing chloride ions.							
Welding properties							
UTP 3127 LC can be welded in all positions except vertical-down. It has a stable arc. Easy and thorough slag removal. The seam has a finely ripped, smooth and regular structure.							
Weld metal analysis in %							
C	Si	Mn	Cr	Mo	Ni	Cu	Fe
< 0,03	< 0,9	1,5	27,0	3,5	31,0	1,3	Balance
Mechanical properties of the weld metal							
Yield strength $R_{P0,2}$	Tensile strength R_m		Elongation A		Impact strength K_V		
> 350 MPa	> 600 MPa		> 30 %		> 50 J		
Welding instructions							
Usual seam preparation. The welding zone must be free from residues, such as grease, paint or metal dust. Weld string beads with max. weaving width 2.5 x core wire diameter. Use the smallest possible stick electrode diameter. Prior to use, the stick electrodes should be re-dried for 2 hours at 120-200°C.							
Welding positions and current type							
		Current type : DC (+) / AC					
Approvals							
TÜV (No. 09466)							
Availability / current adjustment							
Electrodes \varnothing x L [mm]	2,5 x 300		3,2 x 350		4,0 x 350		
Amperage [A]	50-75		80-110		100-150		