

UTP 48

Standard :

Material-No. : 3.2585
DIN 1732 : EL-AISi12

Aluminium stick electrode with 12 % Si and special coating

Application field

UTP 48 is a aluminium stick electrode with 12 % Si and a special coating for joining and surfacing on aluminium-silicon casting alloys with a Si-content up to 12 % Si according to DIN 1725 e.g.

3.2581 G- AISi12
3.2583 G- AISi12(Cu)
3.2383 G- AISi10Mg(Cu)
3.2381 G- AISi10Mg
3.2373 G- AISi9Mg

Welding properties

UTP 48 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 Rp0,2 MPa	Tensile strength Rm MPa	Elongation A %	Melting range ° C
80	180	5	573 - 585

Weld metal analysis in %

Si	Al
12,0	88,0

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*	4,0 x 355*
Amperage	A	50 - 70	80 - 100	90 - 130

* available on request