

UTP 485

Standard :

Material-No. : 3.2245
 DIN 1732 : EL-AISI 5
 AWS A5.3 : E 4043

Aluminium stick electrode with 5 % Si and special coating

Application field

UTP 485 is a aluminium stick electrode with 5 % Si and a special coating for joining and surfacing aluminium-silicon alloys with a Si content of up to 7 % Si and for joining different Al alloys, e. g.

3.3206 AIMgSi0,5
 3.3210 AIMgSi0,7
 3.2315 AIMgSi1
 3.3211 AIMg1SiCu
 3.2371 G- AISi7Mg
 3.2341 G- AISi5Mg
 3.2151 G- AISi6Cu4

Welding properties

UTP 485 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 A5 %	Melting range ° C
90	160	15	573 - 625

Weld metal analysis in %

Si	Al
5,0	95,0

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 350
Amperage	A	50 - 70	80 - 100	90 - 130

* available on request