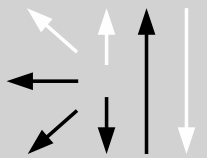


Classifications			
DIN 1732	AWS A5.3		Material-no.
EL-AlSi5	E 4043		3.2245
Characteristics and field of use			
UTP 485 is an aluminium stick electrode with 5% Si and a special coating. It is suitable for joining and surfacing AlSi alloys with a Si content of up to 7% and for dissimilar joints of different Al-alloys, such as:			
3.3206	AlMgSi 0.5	3.2371	G-AlSi 7 Mg
3.3210	AlMgSi 0.7	3.2341	G-AlSi 5 Mg
3.2315	AlMgSi 1	3.2151	G-AlSi 6 Cu 4
3.3211	AlMg 1 SiCu		
UTP 485 is suitable for welding of plates of wall-thicknesses > 2 mm. The soft arc produces a flat, finely-rippled weld seam. Easy slag removal.			
Typical analysis in %			
Al		Si	
95.0		5.0	
Mechanical properties of the pure weld metal			
Yield strength R _{p0,2}	Tensile strength R _m	Elongation A	Melting range
MPa	MPa	%	°C
> 40	> 120	> 8	573 - 625
Welding instruction			
The angle between plate and electrode should be kept between 80-90°. Weld with a short arc. Preheat bigger work pieces with wall thicknesses > 6 mm to 100-250°C in order to ensure a good fusion with the base metal. Raised weld seams indicate too low preheating temperatures.Re-drying: 1 - 1.5 hours at 100°C.			
Welding positions			
 Current type : DC (+)			
Recommended welding parameters			
Electrodes Ø x L [mm]	2.5 x 355	3.2 x 355	4.0 x 355
Amperage [A]	50 – 70	80 – 100	90 - 130