



MIG / TIG Cu

COPPER ALLOY

DESCRIPTION

Very high copper content solid GMAW (MIG) or GTAW (TIG) wire for welding and building up various common grades of pure copper and copper alloys.

CHARACTERISTICS

- Conform to standard AWS A5.7 : ERCu
- Excellent electrical and thermal conductivity
- Smooth fusion
- Excellent resistance to corrosion
- Porosity-free and crack-resistant deposit
- Good colour match on pure copper

TYPICAL APPLICATIONS

Assembly and building up of electrolytic and deoxidized copper. Copper coating on steel and cast iron, statue components, building up of shaft cranks, couplings, electrical copper bus bars, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the joint area. A preheating is generally required for copper. Preheat heavy parts between 400 - 600°C (752 - 1112°F), depending on the thickness.

MECHANICAL PROPERTIES

Tensile strength: 220 MPa (31 000 psi)
 Elongation: 35 %
 Hardness: 55 BH

WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas flow	Gas
GMAW MIG	0.6 mm (.024")	18 - 23	80 - 130	30 à 50 CFH	100 % Argon or Argon + Helium
	0.8 mm (.030")	20 - 25	80 - 180		
	0.9 mm (.035")	22 - 26	100 - 200		
	1.2 mm (.045")	26 - 28	150 - 250		
GTAW TIG	1.6 mm (1/16")	CC-		30 à 40 CFH	100 % Argon or Argon + Helium
	2.5 mm (3/32")				
	3.2 mm (1/8")				

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Specialized welding alloys and technology. For technical assistance or for ordering: