

CATEGORY	GTAW Solid wires	
TYPE	Copper coated welding wire developed for TIG welding of weather resistant steels.	
APPLICATIONS	Weather resistant steels, art constructions, bridges, ovens, deco parts etc.	
PROPERTIES	Due to the addition of 0,5% copper and 0,8% Ni this alloy offers excellent weather resistant properties	
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.28: ER 80S-G 636-A: W 42 4 Z2NiCu 6 1

SUITABLE FOR	<p><b>CuNi, Reh ≤ 460MPa ISO 15608: 1.4</b>                  1.8963, 1.8946, 1.8965                  S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W, WTSt 37, WTSt 52,                  ASTM A 588M Grade A,B, C...K, A 618 Gr. II; A 709 Gr. 50 WF3                  CORten A, B, C, Patinax 37</p>
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APPROVALS	CE
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TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Ni	Cu
0.08	0.6	1.3	0.015	0.015	0.8	0.4

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V -40°C
As Welded /	460	570	22	55

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	KG
1.6 X 1000 MM			5
2.0 X 1000 MM			5
2.4 X 1000 MM			5
3.2 X 1000 MM			5

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	I1
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