


CATEGORY	GTAW Solid wires						
TYPE	Copper based Tig filler metal alloyed with silver						
APPLICATIONS	Electrical contacts, cables, joining copper alloys, rebuilding copper components, installations made from copper tubes etc.						
PROPERTIES	Copper alloy, silver-alloyed-with a slightly higher percentage of phosphor, suitable for TIG welding, easy to handle, high plasticity of the weld metal. High quality alloyed copper wire. The weld metal is a Copper-Silver alloy. Sound, pore free deposits and high electrical conductivity. Excellent corrosion resistance						
CLASSIFICATION	AWS	A 5.7: ERCu					
	EN ISO	24373: Cu 1897 / CuAg1					
	F-nr	31					
	W.Nr.	2.1211					
SUITABLE FOR	Rebuilding and reconditioning electrical contacts.						
APPROVALS	No Approvals Found						
WELDING POSITIONS:							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)							
Si	Mn	P	Fe	Cu	Sn	Al	Ni+Co
0.05	0.1	0.03	0.03	99.8	0.8	0.005	0.2
ALL WELD MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2}	R _m	A ₅	Impact Energy (J) ISO-V			
As Welded /	MPa	MPa	(%)	RT			
	200		30	75			
WELDING PARAMETERS / PACKING							
WELDING PARAMETERS		WELDING PARAMETERS		PACKING (KG)		PACKING (KG)	
D (MM)		CURRENT (A) (DC-)		SINGLE		MASTER	
1,6 X 1000		80-130		5		25	
2.0 X 1000		120-180		5		25	
3.0 X 1000		200-330		5		25	
4.0 X 1000		230-420		5		25	
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175	I1						