



## DESCRIPTION

Electrode with special coating and pure copper core.

Special electrode for welding of copper base alloys. It has an excellent electrical conductivity. It is specific for welding of electrolytic cells and components for steel plants. Phosphorus and silicon act primarily as deoxidizers, the other elements improve ease of welding and the properties of the final weldment. Preheating, 200°C to 500°C, is desirable on most work especially on thick base metal. Also suitable for weld overlays on steel component. Not suitable for stainless steels because Cr pick-up cause embrittlement.

## SPECIFICATIONS

AWS A5.6	ECu	DIN 1733	EL-CuMn2
Shielding	-	Positions	PA, PB, PC, PD, PF
Current	DC+	Packaging Type	Carton box

## ASME QUALIFICATIONS

F-No (QW432)	31
A-No (QW442)	-

## HARDNESS

70HB

CHEM. COMP. %	DEFAULT	MECHANICAL PROPERTIES	MIN. PER STANDARD			PRODUCT
Mn	1.5	Tensile strength R <sub>m</sub> MPa	170			180
Sn	0.9	Yield strength R <sub>p0.2</sub> MPa	-			70
Si	0.2	Elongation A (L <sub>0</sub> =5d <sub>0</sub> ) %	20			33
		Impact Charpy ISO-V	-			-
		Impact Charpy ISO-V	-			-
		WELDING PARAMETERS	2.5 mm	3.2 mm	4.0 mm	
		Ampere	55A - 60A	80A - 90A	100A - 120A	
		Voltage	-	-	-	
		Packaging	pcs/kg	pcs/kg	pcs/kg	
		Packaging Type	Carton box	Carton box	Carton box	

## NOTES

Pcs/kg is indicative, actual number may vary ± 5%.



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**Cu**

DESCRIPTION

COPPER ALLOYS

Cu

#### APPLICATION

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This wire produces a deposit of deoxidized pure copper, ensuring maximum thermal and electrical conductivity. The main applications include plates for chemical plants and molds, distillers, radiators, rods and wires for electrical components, as well as tubes for heat exchangers. A preheating phase is necessary, except for very thin materials with thicknesses less than 3 mm. The required preheating varies: around 100 °C for a thickness of 6 mm, up to 400-500 °C for materials with a thickness of 15 mm.

#### ALLOY TYPE

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Deoxidized pure copper.

#### MICROSTRUCTURE

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Single phase (fcc).

#### MATERIALS

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Oxygen free copper.

