

CuP Tig

CATEGORY	GMAW-GTAW Solid wires	
TYPE	Copper- phosphor alloy for Tig welding	
APPLICATIONS	Welding pure copper, copper to steel, grey cast iron and Nickel alloys with 3 mm wall thickness and more.	
CLASSIFICATION	AWS	A 5.7: no standard
	EN ISO	24373: no standard
	DIN	1733: no standard

SUITABLE FOR	Copper, copper to steel.
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WELDING POSITIONS:	
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FILLER METAL ANALYSIS % (TYPICAL VALUES)	
Cu	P
balance	0.05-0.07

MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V 20°C	Density (Kg/dm ³)	Melting range °C	Hardness HB
AW		220	40	65	8.9	1080	50

AW: as welded

WELDING PARAMETERS / PACKING			
Welding Parameters		Packing	
D (mm)	Current (A) (DC-)	single (kg)	master (kg)
1.6 x 1000	70-150	5	25
2.0 x 1000	125-175	5	25
2.4 x 1000	150-200	5	25
3.2 x 1000	230-400	5	25

REDRYING TEMPERATURE	not required
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GAS ACC. EN ISO 14175:	I1
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