

SP Cu (99,9)

CATEGORY Metal spray wires

TYPE Pure copper wire designed for arc spraying.

APPLICATIONS It is widely used for electrical conductivity and printing roll applications.

PROPERTIES It produces dense, wellbonded coatings with excellent machineability.

CLASSIFICATION
 AWS ASTM: UNS C11000
 EN ISO 13347: Cu-ETP1 CF003A
 DIN E Cu58: Cu-ETP1 CW003A

SUITABLE FOR Conductivity components, worn out copper parts, printing rolls, decoration, art work etc..

APPROVALS CE approved

WELDING POSITIONS:



PURE WIRE ANALYSIS

Cu	Al	Sn	Mn	Si	Pb
>99,9					

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRB
				-20°C	-40°C	-60°C	
							38

SPRAY PARAMETERS / PACKING

Spray parameters					Packing	
D (mm)	Voltage (V)	Current (A)	distance (cm)	air pressure (bar)	spool type	kg spool
1,6	28-30	100-200	10-20	3.5-4.2	K-300	15
3,17	29-32	160-300	14-24	3.5-4.2	Coils	25
4,0				3.5-4.2	Coils	25
4,76				3.5-4.2	Coils	25

REDRYING TEMPERATURE Not required

PREPARATION Recommended method of preparation is, to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe.