


Technical data sheet <small>011121MBA</small>	Copper base – Solid wire WA TCU/MCU Sn	
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CLASSIFICATION

ASME IIC SFA 5.7 / AWS A 5.7: ERCu
EN ISO 24373: S Cu 1898 (CuSn1)

DESCRIPTION

- GTAW rod / GMAW copper base solid wire
- Deposits pure copper

APPLICATIONS

- Welding copper

Examples

SE-Cu (2.0070), SW-Cu (2.0076), SF-Cu (2.0090), OF-Cu (2.0040)

TYPICAL WIRE ANALYSIS [weight %]

Cu	Si	Sn	Mn
98.7	0.3	0.7	0.2



TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
200	50	30	+20°C: 70

All-weld metal hardness: 60 HB

Thermal conductivity: 120 - 135 W/m*K

SHIELDING GAS – OPERATING CONDITIONS – WELDING POSITIONS

GTAW		GMAW	
Shielding gas according to EN ISO 14175	Welding positions Current type	Shielding gas according to EN ISO 14175	Welding positions Current type
I1 (100 % argon)		I1 (100 % argon) I3 (e.g : Ar + 30 % He)	

Preheat sections above 3 mm thick: 100°C/ mm thickness. Do not exceed 600°C.

For preheat temperatures exceeding 300°C, a fluxing agent is recommended.

PACKAGING

Spools	Ø mm	0.8	1.0	1.2	1.6	
Rods	Ø x1000 mm	1.6	2.0	2.4	3.2	4.0

Other dimensions on request

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.