

TECHNICAL SHEET

Cu99,9



Product name

Cu99,9

Class of product

Cu alloy wire for MIG / TIG welding.

Corresponding standards

EN 13347 Cu-DHP CF024A

Werkstoff Nr.: 2.0090

Composition (weight %)

Cu: bal.

P: 0,05 - 0,07

Physical characteristics

Melting range: 1080 °C

Density: 8,9 g/cm³

Thermal conductivity: 293 - 364 W/m K

Coef. of linear expansion (20 – 300 °C): 17,0 10⁻⁶ 1/K

Electric conductivity: 41 - 52 m/Ω mm²

Electric resistivity: 0,0192 – 0,0244 Ω · mm² / mm

Mechanical properties of welded joint (standard data):

Thermal treatment: not treated

Tensile Strength: 220 N/mm²

Elongation: 40 %

Brielle hardness: 50 HB 2,5/62,5

Notched bar impact test: 65 Av(J)

Range of application:

Special copper wire for the production of coated electrodes. Appropriate for electric arc welding of copper, the joining of copper on steel, grey cast iron and nickel alloys of 3 mm wall thickness and more, particularly suitable for large work pieces.

Recommendation:

Applicable inert gas: Argon 4.8 / 5.0 / 5.3 / 5.6 / 6.0

Pulsed arc welding is recommended. Preheating of the base material is usually not required.

Characteristics Make-up:

Rods dia. 2,0 - 6,0 x 1.000 mm

Wires dia. 0,8 – 1,0 – 1,2 – 1,6 – 2,4 (spools, coils and drums)
Other dimensions are available upon request

The above data are subject to change without notice by Spring.

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