

CW-1860

DESCRIPTION & APPLICATION

MIG/TIG Filler Wire for the repair and reclamation of Pure Copper.
Ideal for the joining of Copper Bus-Bars, Electrical Contacts, Calorifiers, and Boilers.

BASE MATERIALS

Copper

MECHANICAL PROPERTIES

200	-	~35	~60
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HB

METAL WELD COMPOSITION %

Cu	Mn	Sn	Si	P	Pb
BAL	0.15	0.5	0.25	0.01	0.005

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

Shielding Gas, Pure Argon or Argon/Helium. Preheat up to 300°C for large sections.
Avoid maintaining temp 340- 650°C for long periods, due to possibility of grain growth.

For more details on welding of Copper Alloys, please see our Information Sheets.
Visit: www.westbrookwelding.co.uk/downloads