

## AUTOCRAFT DEOXIDISED COPPER

### PRODUCT DATA SHEET



**A VERSATILE 98%  
PURE COPPER ALLOY**



### GAS METAL ARC WELDING (MIG) WIRES

#### AUTOCRAFT DEOXIDISED COPPER

- For GMAW Joining and Overlay Applications.
- Repair of Copper Castings.
- Fabricating Deoxidised Copper and Electrolytic Pitch Copper Components.
- Lower Strength Welding of Galvanised Steels and Deoxidised Copper to Mild Steel Joints.

#### CLASSIFICATIONS:

AWS/ASME-SFA A5.7:

ERCU

#### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

##### WELDING GRADE ARGON:

0.2% Proof Stress	55 MPa
Tensile Strength	200 MPa
Elongation (in 2 inches)	30%
Electrical Conductivity	40% IACS
Hardness	55 BHN
Weld Metal Density	7.47 x 103 kg/m <sup>3</sup>

DESCRIPTION AND APPLICATIONS:

Autocraft Deoxidised Copper is a versatile 98% pure Copper alloy for the GMAW welding of:

- Deoxidised and electrolytic tough pitch copper components
- Copper castings and galvanised steels
- Dissimilar mild steel to deoxidised copper joints

Autocraft Deoxidised Copper should only be used for the GMAW welding of galvanised steel and for dissimilar welding of mild steel to deoxidised copper where high strength joints are not required.

Typical applications include the GMAW welding of copper transformer connectors, copper bus bars, billet molds and heater elements etc.

Autocraft Deoxidised Copper can also be used as a corrosion resistant overlay.

TYPICAL WIRE ANALYSIS LIMITS:

Mn:	0.5%
Si:	0.5%
P:	0.15%
Sn:	1.0%
Cu:	98.0% min
Others:	0.50%

Single values are maximum allowable, unless otherwise stated

PACKAGING & OPERATING DATA:

These machine settings are a guide only. Actual voltage and welding current used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

WIRE DIAMETER (MM)	VOLTAGE RANGE (VOLTS)	WIRE FEED SPEED (METERS/MIN)	CURRENT RANGE (AMPS)	PACK TYPE	PACK WEIGHT	PART NO.
1.6	28-32	5.5-11.5	160-380	Spool*	13kg	720260
1.6	28-32	5.5-11.5	160-380	Drum	200kg	720260D

\* Spool (ø300mm);

RECOMMENDED\* SHIELDING GAS:

AS 4882:	SG-A SG-AHe-25 SG-HeA-25
ISO 14175 / AWS A5.32:	11*- CERT SUPPLIED 13 13

Welding grade Ar or Ar+He (25%) or He+Ar (25%)

WELDING POSITIONS:

All positional welding applications.

