

Standards

TS EN ISO 17672	: Cu 511
EN ISO 17672	: Cu 511
AWS A5.7	: ER Cu

Chemical Composition of Weld Metal % (Typical)

Sn	Si	Mn	Cu
0.8	0.3	0.3	Rest

Mechanical Properties


Tensile Strength (N/mm ²)	Impact Strength (J)	Elongation ((L ₀ =5d ₀) (%))	Hardness (HB)	Melting Range (°C)	Electrical Conductivity (20°C) (Sm/mm ²)	Thermal Conductivity (W/m.K)	Density (kg/dm ³)
200	70	30	60	1020-1050	15-20	120-170	8.9

Features and Applications

- Used in joining and filler welds of blister copper
- The weld metal has strength to the overheat
- Electrode holders, blast furnace tuyeres, some copper parts of radiator and oil coolers are the primary application area of this consumable
- 300°C pre-heat must be done to the copper plates thinner than 3 mm
- Used for steel and nickel brazing
- Shielding gas : TIG (Ar or %75 Ar+ %25He)

Welding Method

Gas Welding - TIG Welding

Current Type	MIGWire	Electrode	Welding Positions
TIG D.C.(-)	Geka R1 L	GeKaTec Cu-WELD	

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100086	2.0 x 1000	5/64 x 39"	5

Approvals: GOST-R, SEPRO