Standards

AWS A5.6 : E Cu

Chemical Composition of Weld Metal % (Typical)

Cu
min.99

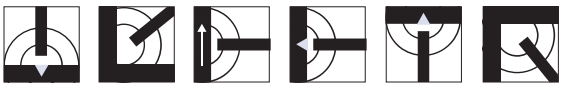
Mechanical Properties

Tensile Strength (N/mm^2)	Elongation ($(L_o=5d_o)$ (%))	Hardness (HB)
min. 200	min. 25	55

Features and Applications

- Electrode made of pure copper
- Uses in joint-welding and surfacing operations on pure copper or on copper alloys
- Applicability in joint- welding of boilers, heat exchangers, or, of copper tubes, copper busbars used in electrotechnics, copper busbars as well as in copper surfacing on steel materials
- Requirement of applying as high current as possible in joint- welding
- Pre-heating requirement of base materials of copper or copper alloys at temperatures of 400°C - 450°C for all welding applications on them

Welding Positions



MIG Wire

GeKa R1 L

TIG Wire

GeKaTec S1 L

Current Type

D.C.(+) / AC

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)
6031200015	3.20 x 350	1/8 x 14”	90 - 120	5
6031200016	4.00 x 350	5/32 x 14”	120 - 150	5

Approvals: SEPRO