

# TALWELD De-Ox

## Classification

AWS.A5.7 ERCu

## Description

TALWELD DE-OX (ERCu) filler metal is deoxidized copper with small quantities of phosphorus, silicon, tin and manganese. The phosphorus and silicon are primarily deoxidizers, while silicon and other elements improve fluidity and ease of welding.

## Application

This metal is normally used to weld deoxidized copper (C12000 and C12200) and electrolytic tough pitch copper (C11000). Preheating is desirable for most work, but it is essential for heavier gauge welding. Preheating temperatures of 205°C to 540°C are recommended.

## Shielding Gas

Welding grade Argon or Argon/Helium mixtures

## Chemical Composition of Solid Wire

Cu	Sn	Mn	Si	Al	P	Pb	Total Others
98.0 Min.	1.0 Max.	0.5 Max.	0.5 Max.	0.01 Max.	0.15 Max.	0.02 Max.	0.50 Max.

## Typical Mechanical Properties of Weldmetal

Tensile strength	Yield strength	Elongation
210 MPa	60 MPa	29%

## Packaging and Machine Settings – GMAW

Diam. (mm)	1.2	1.6
Spool (300mm)	13.6 kg	13.6 kg
Volts	21-29	25-35
Current, A	180-270	240-340

Diam.	13.6kg Spool
1.2mm	CMCDEOX12
1.6mm	CMCDEOX16