

TALWELD De-Ox TIG

Classification

AWS.A5.7 ERCu

Description

TALWELD DE-OX (ER Cu) 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 for GTAW (TIG)

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

Diam. (mm)	1.6	2.4	3.2
Pack	5kg	5kg	5kg
Length (mm)	1000	1000	1000

Diam.	5kg Pack
1.6mm	CTCDEOX16
2.4mm	CTCDEOX24
3.2mm	CTCDEOX32

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