

# TALARC Cu

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER80S-G	(EN ISO 16834-A: G Mn3Ni1Cu)

## ALLOY TYPE

Copper-coated solid wire for welding weather-resistant steels.

## APPLICATIONS

Low-alloy copper-coated solid wire with Ni-Cu-Cr additions designed for weather-resistant steel. Thanks to the chemical composition and weld metal mechanical properties it is also used for welding high tensile strength steels. Suitable for the construction of containers, tanks, bridges, building panels, chimneys, means of transport, offshore platforms, etc. The weld material shows a good resistance to atmospheric corrosion and salt water. To be used under the shield of Ar+CO<sub>2</sub>.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
0.08	1.40	0.75	0.01	0.01	0.30	0.70	-	0.40

## TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C	-50°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
<b>MIX</b>	as welded	530	620	26	130	110	90	70	50

## WELDING GUIDELINES

Interpass temperature 150°C. Preheat and PWHT are not required.

## TECHNICAL INFORMATION

Gas: Mix Ar- CO<sub>2</sub> (EN 14175)

Welding position: all positions



## WELDING PARAMETERS

Current	DC + Reverse polarity		
	0.9	1.2	
Diameter (mm)			
Volts (V)	17 ÷ 30	18 ÷ 34	
Intensity (A)	70 ÷ 240	100 ÷ 360	

Diam.	15kg Spool
0.9mm	INMCU09
1.2mm	INMCU12

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