



## MIG CUAG

### Classification

ISO 24373 : S Cu 1897 (CuAg1)

### Description & Applications

Solid wire for GMAW of Oxygen free Copper and Copper alloys where a high electrical conductivity is required.

**Main applications:** Electrical conductor.

### Typical Chemical Composition ( % )

	Al	Fe	Mn	Ni+Co	P	Pb	Si	As	Ag	O/T	Cu+Ag
Min					0.01				0.8		99.5
Max	0.01	0.05	0.2	0.3	0.05	0.01	0.1	0.05	1.2	0.2	
Type	0.001	0.01	0.06	0.02	0.015	0.005	0.02	0.01	0.9	<0.2	>99.5

### All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Electrical conductivity (S.m/mm <sup>2</sup> )
Min	-	-	-	
Max				
Type	60	190	35	40-46

### Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	120 - 180	20 - 22	ISO 14175: I1 (100% Ar) I2 (100% He) I3 (Ar+ 5-30%He) 12-18 l/min
	1.0	180 - 220	22 - 24	
	1.2	220 - 250	24 - 26	

Preheating of massive parts between 200°C (>6mm) up to 500°C (>15mm).

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**Fumes:** Consult information on MSDS, available upon request.

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