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

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	Electrical conductivity ($S.m/mm^2$)
Min	-	-	-	
Max				
Type	60	190	35	40-46

Welding Current & Instructions

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

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