TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP C7

COPPER ALLOYS

CLASSIFICATIONS

EN ISO 24373	AWS A5.7
S Cu 1898 (CuSn1)	ERCu

KEY FEATURES AND APPLICATIONS

- Solid copper-tin wire used primarily on highly stressed welded joints on oxygen-free copper and Cu materials.
- Suitable for build-up welding on copper alloys and unalloyed ferrous materials.
- Depending on the base material thickness, preheating may be required.
- Typically used on components in the chemical, paper, food and textile industries as well as shipbuilding, conductor rails, electrical contacts, pipelines, containers, flanges and fittings etc.

BASE MATERIALS

2.0040, 2.0060, 2.0070, 2.0080, 2.0090, 2.0100, 2.0120, 2.0150, 2.0170, 2.1202, 2.1322, 2.1325, 2.1491

CHEMICAL COMPOSITION OF WIRE %

	Cu	Al	Mn	P	Pb	Si	Sn	Others
MIN	min. 98.0	-	-	-	-	-	-	-
MAX		0.01	0.50	0.15	0.02	0.50	1.0	0.50

Single values are maximum values according to EN ISO 24373 unless otherwise stated

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Tensile Strength (MPa)	Hardness (HRF)	Melting Temperature
≥170	≥25	1020 - 1050°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1, I3	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP40316	1.6	1000	5	PAP 20 Tube
XP40317	2.4	1000	5	PAP 20 Tube
XP40318	3.2	1000	5	PAP 20 Tube