



CLASSIFICATIONS

EN ISO 20378	AWS A5.2
O I	R45

KEY FEATURES AND APPLICATIONS

- Solid unalloyed copper coated wire designed for oxy-fuel welding applications.
- Suitable for welding mild steel plates, sheets, pipes, and other components where high mechanical strength properties are not critical requirements.
- Produces homogeneous and soft weld deposits with excellent malleability.

BASE MATERIALS

S185, S235JR, St33, St52, St35, St35.8, 1.0035, 1.0561, 1.0308, 1.0305

ASTM A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Mo	Ni	Cr	Cu	V
MIN	0.03	0.01	0.35	-	-	-	-	-	-	-
MAX	0.12	0.20	0.65	0.030	0.025	0.3	0.3	0.15	0.35	0.03

Single values are maximum values according to EN ISO 20378

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
280 (NS)	400 (≥310)	20 (NS)	30 (NS)	-20°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables - (NS) - Not Specified

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP10600	1.6	1000	5	PAP 20 Tube
XP10603	2.4	1000	5	PAP 20 Tube
XP10606	3.2	1000	5	PAP 20 Tube