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## REASON FOR ISSUE

Update of classification and chemical composition.

## GENERAL

Bare copper welding rod alloyed with small amounts of tin for welding of oxygen free, pure copper and low alloyed copper. The weld is easily workable. For welding of large work pieces and heavy thickness preheating is recommended..

**Shielding Gas:** I1, I2, I3 (EN 439)

**Alloy Type:** Copper (Cu + 0.7 % Sn)

## CLASSIFICATIONS Wire Electrode

SFA/AWS A5.7      ERCu  
EN ISO 24373      CuSn1

## APPROVALS

Not applicable

## CHEMICAL COMPOSITION

### Wire/Strip (%)

	Min	Max
Si		0.50
Mn		0.50
P		0.15
Cu	98.0	
Al		0.01
Sn		1.0
Pb		0.01
As		0.05
Fe		0.05
Ni+Co		0.3
Others tot		0.5

## MECHANICAL PROPERTIES OF WELD METAL

### All Weld Metal

Properties	As welded	
	Typ	
Rp0.2 (MPa)	75	
Rm (MPa)	220	
A4-A5 (%)	30	