

FONTARGEN A 200 M

Copper wire electrode for MIG-welding



ISO 24373: S Cu 1897 (CuAg1)
AWS A 5.7: ERCu
Material-no.: 2.1211

Composition, typical analysis (% w/w):

Ag	Mn	Cu
1	0.1	Remainder

Characteristics / Applications:

Joint and build-up welding on copper, for example material numbers: 2.0060 (E-Cu 57), 2.0070 (SE-Cu), 2.0090 (SF-Cu), 2.0110 (SD-Cu), 2.0150 (SB-Cu), 2.0170 (SA-Cu), 2.1202 (Cu Ag), plates, profiles, containers.

Very easily processed copper alloy. Semi-fluid. Suited for difficult welding positions. The welding pool is clean and clear. The welding deposit is tough and non-porous. Colour and structure of the welding deposit like copper. For workpieces that must be polished, use in limited fashion, as silver can cause blackening. Preheat large workpieces to 350 - 600 °C; use Ar-He inert-gas mixture if necessary.

Mechanical properties of pure welding deposit

(Min. values at room temperature):

Melting range: 1070 - 1080 °C
Tensile strength: 200 N/mm²
Elongation limit (0.2 %): 80 N/mm²
Elongation (l=5d): 30 %
Thermal elongation: $17.7 \cdot 10^{-6}/K$
Hardness (Brinell): 60 HB
Electrical conductivity: 44 - 46 Sm/mm²
Heat conductivity: 220 - 315 W/m • K
Specific gravity: 8.9 g/cm³

Welding process: MIG

Shielding gas (DIN EN 439): I 1 (Argon), I 3 (Ar-He mixture)

Current mode: DC (+pole)

Availability: Diameter (mm): 0.8/1.0/1.2/1.6/2.4

Spool type: B300, S300

Welding position: according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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