

FONTARGEN A 200 W

Copper welding rod



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

Composition, typical analysis (% w/w):

Ag	P	Mn	Cu
1	0.02	0.1	Remainder

Characteristics / Applications:

Joint and build-up welding on copper, for example material numbers: 2.0040 (OF-Cu), 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. Suited for copper pipe installations in accordance with DVGW work sheet GW 2.

Preheat large work pieces to 350 °C - 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/mm ²
Yield strength (0.2 %):	80 N/mm ²
Elongation (l=5d):	30 %
Hardness (BHN):	60 HB
Impact energy:	75 J
Heat conductivity:	220 - 315 W/m • K
Electrical conductivity (20 °C):	44 - 46 Sm/mm ²
Thermal elongation:	17.7 • 10 ⁻⁶ /K
Specific gravity:	8.9 kg/dm ³

Welding process: TIG, gas welding

Shielding gas (DIN EN 439): I 1 (Argon)
I 3 (Argon/Helium mixture)

Flux: F 100 (Paste) at preheating to > 300 °C

Current mode: DC (-pole)

Availability: Diameter (mm): 1.6/2.0/2.4/3.2
Length (mm): 1000

Welding position: according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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