

CUROD is a S Cu 1898 / ER Cu type solid TIG welding rod depositing a pure copper weld metal. Suitable for welding mainly with Ar shielding gas.

CUROD is generally used for welding of deoxidised and electrolytic tough pitch copper and copper alloys. Suitable for wear-resistant surfacing, and also for oxyacetylene welding. In last case use deoxiders. The main applications include car and bus production, electrical domestic appliances, surfacing and pipes fabrication.

It is necessary to pre-heat the base material for section >3 mm. Good sliding.

Classification

EN	24373: S Cu 18 98 (CuSn1)
AWS	A5.7: ER Cu

Chemical analysis (Typical values in %)

	Mn	Si	P	Cu	Pb	Sn	Al
Wire	0.3	0.3	≤ 0.15	≥ 98.0	≤ 0.02	0.75	≤ 0.01

All-weld metal Mechanical Properties

Heat Treatment	Tensile Strength (MPa)
As Welded	210-245

Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

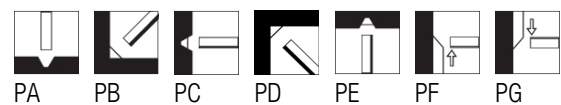
Copper and Cu-alloys, like 2.0040, 2.0070, 2.0076, 2.0090, 2.1310, 2.1498, 2.1546

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	W000283602
2.0	TUB	5	W000283603
2.4	TUB	5	W000272190