

BERCOWELD[®] K8 (CuAg/G)

Cu-alloy wire electrode for TIG and gas welding

Standard designation ISO 24373 : Cu 1897 CuAg1

Composition (weight %)

Cu	: balance
Ag	: 0,80-1,00
P	: 0,025-0,050
Mn	: 0,05-0,12
Others	: max. 0,5

Physical standard data

Density	kg/dm ³	: 8,9
Melting range	° C	: 1070-1080
Thermal conductivity	W/m· K	: 220-315
Coefficient of linear mean expansion (20°C-300°C)	1/ K	: 17,7·10 ⁻⁶
Electric conductivity	m/Ω·mm ²	: 38-40
Resistivity	Ω·mm ² /m	: 0,025-0,0263

Mechanical properties of the weld joint, standard data

Heat treatment		non treated
Tensile strenght	N/mm ²	: 200
Elongation	%	: 30
Brinell hardness	HB 2,5/62,5	: 60
Notched bar impact test	A _v (J)	: 75

Range of applications

Copper-silver material. Specially suited for build-up and join welding on copper, pre-heat large work pieces to around 450°C.

Recommendation

Applicable inert gas Argon 4.8/ 5.0/ 5.3/ 5.6/ 6.0

Make up

Diameters: 0,80 - 1,00 - 1,20 - 1,60 - and 2,40 mm.
Spools: D 300, H 370 and wire basket spools (acc. to DIN 8559).
Rods: 2,00 - 6,00 mm Ø x 1000 mm.
Further make ups on request.

www.bercoweld.com