



...better ways to join metals

®

TECHNICAL SPECIFICATION SHEET

HARRIS PRODUCTS GROUP
4501 QUALITY PLACE
MASON, OHIO 45040
TEL. (513) 754-2000
FAX, (513) 754-8778
www.harrisproductsgroup.com

DEOXIDIZED COPPER WELDING WIRE

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
ARC RAYS can injure eyes and burn skin.
ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

STATEMENT OF LIABILITY — DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. Harris Products Group and its affiliates shall have no liability in respect thereof.

NOMINAL COMPOSITION:

Manganese	.50 % max.	Tin	1.0 % max.
Lead	.02 % max.	Phosphorus	.15 % max.
Copper	98.0 % min.	Silicon	.50 % max.
Aluminum	.01 % max.	Others	.50 % max.

PHYSICAL PROPERTIES:

Melting Point	1967° f (1075° C)	Reduction of area	45 %
Yield Strength	8,000 psi	Tensile Strength	29,000 psi.
Elongation	29 %	Electrical Conductivity (%IACS)	40%
Brinell Hardness	54 HB (500 kg load)		

Page 1 of 2

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APPLICATION:

Used to weld copper base metals where good electrical conductivity

RECOMMENDED WELDING PARAMETERS:

***GMAW (MIG) Parameters** (DC Reverse Polarity) Electrode Positive Spray transfer

<u>Wire Diameter</u>	<u>Amps</u>	<u>Volts</u>	<u>Argon (cfh)</u>	<u>Wire Feed ipm</u>
.030	130-150	21-23	25	460-500
.035	145-185	23-25	30	400-440
.045	195-215	26-28	30	280-310
1/16	260-280	27-30	40	150-210

***GTAW (Tig) Parameters** (DCSP) ² Electrode negative or ACHF

<u>Material</u>	<u>2%Thoriated ²</u>	<u>Filler Wire Size</u>	<u>Amps (DC)</u>	<u>Amps (AC)</u>	<u>Gas Cup</u>	<u>Argon(cfh)</u>
1/16"	1/16"	1/16"	70-150	70-150	3/8-1/2	15
3/32"-1/8"	3/32"	3/32"	150-200	140-230	7/16-1/2	15
3/16"- 1/2"	1/8"	3/32"-1/8"	230-400	225-320	7/16-1/2	20
1/2"-1"	3/16"	3/16"-1/4"	325-500	290-485	1/2	25

* All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.

SPECIFICATION COMPLIANCE: ANSI/AWS A 5.7 & ASME SFA-5.7 ERCu

Harris Products Group	Fax	513-754-8778
4501 Quality Place	Tel.	513-754-2000
Mason, Ohio 45040		800-733-4533

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