

GETIG 7200

DEOXIDIZED COPPER FILLER ROD.

IDENTIFICATION

Getig 7200, ER Cu

CLASSIFICATION

AWS/SFA 5.7: ERCu

DESCRIPTION

Copper alloy for welding deoxidized copper. The molten pool is clean. The deposit is tough and free from porosity.

ALLOY BASIS: Cu, Ag, P

CHEMICAL ANALYSIS (RANGE) %

| Al | Mn | Sn | Si | P | Cu |
|----------|----------|---------|----------|----------|----------|
| 0.01 max | 0.50 max | 1.0 max | 0.50 max | 0.15 max | 98.0 min |

TYPICAL APPLICATIONS

- Deoxidized copper welding rod used for joining and surfacing of copper.
- Used in chemical, food, paper, textile, brewery and shipbuilding industries.
- Suitable for furnace brazing of steels.

HEAT SOURCES : Acetylene torch, neutral flame. TIG/MIG processes.

PROCEDURES

Prepare V-groove of about 60° where thickness is more than 5mm. Clean the joint thoroughly. Apply flux on the joint area. Use neutral flame. Preheat a broad area, then heat locally until flux melts. Apply the flux to the rod by dipping heated end into the flux and melt the rod in to the joint.

CLEANING

Remove flux residues mechanically or chemically (using 10% sulphuric acid) followed by rinsing in running water.

PACKING PARAMETERS

| Size (mm) | Length (mm) | Packing / Pkt (kg) | Packing / Box (kg) |
|-------------|-------------|--------------------|--------------------|
| 1.6 | 500 / 1000 | 2 | 2 x 5 = 10 |
| 2 | 500 / 1000 | 2 | 2 x 5 = 10 |
| 2.40 / 2.50 | 500 / 1000 | 2 | 2 x 5 = 10 |
| 3.15 / 3.20 | 500 / 1000 | 2 | 2 x 5 = 10 |