

GM 7200

FOR GMAW, JOINING AND OVER BY APPLICATION.

IDENTIFICATION

GM 7200, ERCu

CLASSIFICATION

AWS/SFA 5.7: ER Cu

DESCRIPTION

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

ALLOY BASE : Cu, Ag, p

CHEMICAL ANALYSIS (RANGE) %

Cu	Sn	Mn	Si	P
98.0 max	1.0 max	0.50 max	0.50 max	0.15 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)
170 - 240

TYPICAL APPLICATIONS

- Deoxidized copper welding wire 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.

PROCEDURE

Prepare V-groove of about 600 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.

SHIELDING GAS : Welding grade Argon OR 80% Argon + 20% Helium

PACKING PARAMETERS

Size (mm)	Voltage	Current (Amps)	Weight / Spool (kg)
1.2	22 - 28	100 - 250	12.5 / 15.0
1.6	28 - 32	160 - 380	12.5 / 15.0