

IABCO C7

MIG/GMAW and TIG/GTAW copper base wire

Product name	IABCO C7
Classification EN ISO	24373: Cu1898 (CuSn1)
Classification AWS	A5.7: ERcCu
Classification BS	2901 part 3: C7 (obsolete specification)
Applications	Copper base wire producing a deoxidised pure copper deposit. Applications include electrical components and heat exchangers where high electrical and thermal conductivity is required. Uses are also found in chemical plant, stills (brewing) and moulds.
Base materials	Oxygen free copper: C10200, Cu-OF, Cu-OFS.
Typical analysis of wire, weight %	Cu: Balance Sn: 0.8 Mn: 0.2 Si: 0.2
Typical heat treatment ⁽¹⁾	Preheat: For thin material (<3mm) probably not necessary but as material thickness increases preheat will need to increase; rising from 100-200°C at 6mm thick up to 350-450°C at 12mm thick. Preheat can be minimised by using He or He-Ar shielding gas in preference to Ar. Interpass: Maintained above the preheat temperature. PWHT: Not required for most applications.
Typical mechanical properties of weld ⁽²⁾	0.2% proof stress Rp0.2%: 70MPa Tensile strength Rm: 220MPa Elongation 5d: 30%
Other products	-

- Notes** (1) Application codes and project specifications should always be referred to for specific requirements.
(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.