

PRODUCT INFORMATION

SIFSILCOPPER No 7

EN 14640 Cu 1897 (CuAg1),
BS: 1453 C1

DESCRIPTION

An easy flowing, high quality copper rod for full fusion welding of deoxidised copper sheet. The finished weld is free from porosity and copper oxide inclusions. Suitable for use in the oxy/acetylene brazing process (use SIFSILCOPPER flux). Also commonly used in TIG welding. Suitable for fabrication and repairs to copper pipes, tanks etc.

WELDING POSITIONS



Suitable for use in ship building, repair and maintenance, and the brewing, offshore, and process industries. This alloy also provides good electrical conductivity and is often used in machinery constructions and conductor rail manufacture.

TYPICAL WELD METAL COMPOSITION

Ag	1 %
Cu	Bal

TYPICAL MECHANICAL PROPERTIES

Melting Point	1060 °C
Ult Tensile Strength	200 N/mm²
Hardness	75

MATERIAL TO BE WELDED

The rod can be used for fabrication of stills for the brewing industry, repairs to copper pipes and castings, calorifiers, fireboxes and copper fittings. It exhibits a viscous weld pool and is typically best used on oxygen-free copper types. A pre-heat may be required on material thicknesses of 73mm (to a maximum of 60 °C).

AVAILABLE FORMATS

1M ROD (TIG / GTAW)			
Dia	1kg Pkt	2.5kg Ctn	5.0kg Ctn
1.6mm	RO071601	RO071625	RO071650
2.4mm	RO072401	RO072425	RO072450
3.2mm	RO073201	RO073225	RO073250

Gas Welding – Oxy / Acetylene	
Tig Welding	
Current	DC = +
Amps	50 – 220
Shielding Gas	Pure Argon

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@wholeweld.co.uk**

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