



## EWB<sup>®</sup> – ER Cu MIG / TIG Welding Wires

### Classifications:

AWS A5.7: ERCu

ISO 24373: CuSn

### Typical Chemistry Composition of Weld Deposit (%):

Cu	Sn	Mn	P	Si	Others
Balance	0.75 – 0.90	0.15 – 0.30	0.005 – 0.20	0.15 – 0.25	<0.50

### Description & Applications:

- Tin alloyed copper welding filler metal with good flowing properties and suitable for joining of OF-copper and copper materials which are subject to high strain
- Welding seams are obtained without pores.
- For TIG welding of large work pieces preheating to 300°C is recommended.

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
70	200	30

### Welding Parameters:

Wire Diameter (Ø in mm)	0.80	1.00	1.20
Current (A)	60 – 165	80 – 210	150 – 320
Voltage (V)	13 – 17.5	12.5 – 18	16 – 29

### Packing Available:-

**MIG/MAG Wire** (Ø in mm): 0.80 / 1.00 / 1.20

**TIG Wire** (Ø in mm): 1.60 / 2.40 / 3.20 / 4.00

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### EWB Weld

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