PRODUCT SPECIFICATION

Lastek 53

Welding pure copper

CLASSIFICATION

EN ISO 24373 : Cu 1897 CuAg1
AWS A5.7 : ER Cu

GENERAL DESCRIPTION

Copper-silver alloy for oxyacetylene or TIG welding of red copper.
The weld metal is tough and can be deformed without danger for cracking.
High electrical conductivity.
The high silver content gives to the deposit a higher softening point, making this rod excellent for rebuilding electrical contacts.

APPLICATIONS

Copper kettles, boilers, tubes, joinings of electrical conductors, refacing electrical contacts.
Food industry.

Hardness: 60 HB
Bonding temperature: 900 °C (1650 °F)
Electrical resistivity: 0.022 to 0.033 ohm.mm²/m

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Ag : 0.80 - 1.00	**Mn :** 0.04 - 0.12	**P :** 0.025 - 0.05	**Cu :** Balance	**ll others** < 0.05

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	400 - 550 MPa	1% - 10%	

GENERAL INFORMATION

Welding positions	NA			
Shielding gas	For tig welding: Ar or Ar/He mixture			
Packing	5 kg in a cardboard box			
Polarity	DC, with the torch on the negative pole.			
Diameter (mm)	1.5	2.0	3.0	4.0
Lenght (mm)	1000	1000	1000	1000

Tips & tricks

Clean the pieces thoroughly, eliminate oil and grease.
Weld with a neutral flame and use the flux Lastek 53A.
Preheat larger work pieces in red copper up to 350-600 °C (660-1110 °F).
Use a torch tip one or two sizes larger than you would use on steel of equivalent thickness.