

HABCO CA 690 (S)

PURE COPPER ELECTRODE FOR JOINING OF COPPER AND COPPER FERROUS ALLOYS

FEATURES

Smooth running pure copper electrode for welding all types of copper, copper alloys and copper-nickel alloys. Provides a porosity free deposit and has excellent corrosion resistance.

APPLICATIONS

Ideal for applications requiring, high corrosion resistance, thermal and electrical conductivity. For joining and copper cladding of steel, cast iron and other copper alloys.

INSTRUCTIONS

Clean joint area, removing all oxides and foreign material. Thin sections do not require pre-heating. Sections longer than 3/16" (5mm) require pre-heating up to 1100°F (600°C). Maintain a short arc while weaving the electrode slightly. For multi-pass welding, peen immediately after each pass. Allow to cool slowly before removing slag.

Tensile Strength: up to 31,000 Psi (22 kg/mm²)

Elongation: up to 35%

Hardness: 50–60 BH

Corrosion Resistance: Excellent

Electrical Conductivity: Very Good

Current: DC +

Amperage:	100-130	140-170	170-200
Diameters: (in)	1/8	5/32	3/16
(mm)	3.25	4.0	5.0

- Available in (GTAW) TIG and (GMAW) MIG form