



**PRODUCT INFORMATION**

**SIFSILCOPPER NO 985**

ISO 24373 Cu 1898 (CusSn1)  
BS 2901 C7

**DESCRIPTION**

A high-quality copper TIG rod for full fusion welding of deoxidised copper sheet. The deposit is easy flowing and the finished weld is free from copper oxide inclusions. Commonly used in TIG welding for fabrication and repairs of copper pipes, tanks, buzz-bars, etc.

**WELDING POSITIONS**



Used in a variety of coppersmith applications. Also provides good electrical conductivity so is often used in machinery construction and conductor manufacture.

**TYPICAL WELD METAL COMPOSITION**

Cu	Bal
Sn	0.8
Si	0.3
Mn	0.3

**TYPICAL MECHANICAL PROPERTIES**

Ult Tensile Strength	225 MPa
Yield Stress	75 MPa
Elongation	30%
Impact Value	75 J (+20°C)

**MATERIAL TO BE WELDED**

SifSilCopper 985 delivers a viscous weld pool and is typically best used on oxygen-free copper types. A pre-heat may be required on material thicknesses over 50mm (to a maximum of 50°C).

**AVAILABLE FORMATS**

1M Rod (TIG / GTAW)			
Dia	1.0kg	2.5kg	5.0kg
1.2mm	RO981201	RO981225	RO981250
1.6mm	RO981601	RO981625	RO981650
2.4mm	RO982401	RO982425	RO982450
3.2mm	RO983201	RO983225	RO983250

Shielding Gas :	Pure Argon
Current :	DC=+
Amps	60 - 230

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@weldability-sif.com](mailto:service@weldability-sif.com)



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