

Dated: January 15, 2002

TYPICAL APPLICATIONS

Eureka Everdur 1010 Bare Rod is copper-silicon-manganese alloy welding rod used to weld copper, brass and dissimilar combinations. Excellent results when used on galvanized and thins sheet metal using Tig or Mig.

SPECIFICATIONS

**AWS A 5.7 & A 5.13
ER CuSi-A**

Sn	1.00 max.
Zn	1.00 max.
Fe	0.50 max.
Si	2.80 – 4.00
Mn	1.50 max.
Others	0.50 max.
Cu	Remainder
Melting Point	1866°
Tensile Strength	58,000 PSI
Yield Strength	25,000 PSI
Elongation	54%
Hardness	93 Brinnell

PROCEDURES

Clean joint area thoroughly. Use DC reverse polarity for Mig welding with argon shielding gas. For Tig welding, we use DC straight polarity or AC with argon shielding gas. For Torch application, dip heated rod into flux and proceed to finish flowing alloy into joint until it is completed.

SIZES

1/16" x 36"
3/32" x 36"
1/8" x 36"

Technical Data