

WIRBALIT® HF

CuCr1Zr - 2.1293 - CW106C

Nominal composition:

HF - wt.-% (approx. value) Cr0,65 - Zr0,08 - Cu rem.

A high-strength age-hardened electrode material for spot welding, in particular high-cycle continuous or roller spot welding. Suitable for all steels - including alloyed and stainless grades - and for coated and galvanized sheet.

		A	B	C
Tensile strength Rm	MPa	≥ 540	≥ 490	≥ 460
Yield strength Rp0,2	MPa	≥ 470	≥ 440	≥ 400
Elongation A	%	≥ 10	≥ 10	≥ 16
Reduction of Area Z	%	≥ 50	≥ 50	≥ 60
Hardness HBW 2,5/62,5		160–185	150–180	140–165
Hardness HV30		165–190	160–185	145–170
Hardness HRB		81–90	79–89	73–83
El. conductivity	MS/m	≥ 44	≥ 44	≥ 46
El. conductivity	% IACS	≥ 76	≥ 76	≥ 80

C Special grade for cold bending.
Coils/wire up to \varnothing 10 mm OD or width a/f.

Shapes, sizes and tempers

Rod



Diameter (mm)

B	A	B
3	10	25–30



Width a/f (mm)

B	A	B
5	10	20–25

Further sizes and special grades on request.