

TUCO

Technical Datasheet

Short Name	-	Chemical Composition (weight %)		Standard-Classification	
Material-No. (old)	-	W	Cu		
Code	TUCO 80/20	80	20	ISO 5182	Group B, Class 11
	TUCO 75/25	75	25	ISO 5182	Group B, Class 10
	TUCO 70/30	70	30	ISO 5182	

Material-Properties

A powdermetallurgically produced tungsten-copper composite material. It combines tungsten's high resistance to arc erosion with the extremely good electrical conductivity of copper in the same material.

Applications

- Electrodes for projection- and butt-welding
- Electrodes for electrical riveting
- Wear resistant electrodes for sparc erosion
- High performance contacts for hot upsetting machines

Mechanical Properties (Reference values)

		TUCO 80/20	TUCO 75/25	TUCO 70/30
Hardness	HV	230	200	170
Tensile strength	N/mm ²	490	440	390
Modulus of elasticity	kN/mm ²	230	225	225

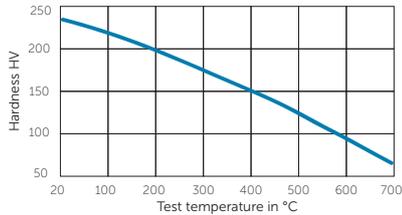
Physical Properties

Electrical conductivity 20 °C (293 K)	$\frac{m}{\Omega \cdot mm^2}$	15	22	29
Electrical resistance 20 °C (293 K)	$\frac{\Omega \cdot mm^2}{m}$	0.07	0.04	0.03
Coefficient of electrical resistance	$\frac{1}{K}$	-	-	-
Coefficient of thermal expansion	$\frac{1}{K}$	-	-	-
Thermal conductivity 20 °C (293 K)	$\frac{W}{m \cdot K}$	130	140	150
Density	g/cm ³	15.3	14.6	14.0

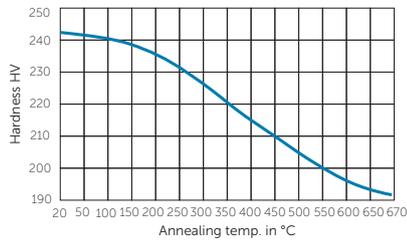
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Hardness at elevated temperatures
from TUCO 80/20



Softening from TUCO 80/20



Machining Instructions

Drilling	Tungsten Carbide ISO K 05	Twist drills in acc. with DIN 338
Cutting speed m/min.	40	15 – 20
Lip angle	118 – 120°	like with steel machining
Machining	dry	dry

Turning	Tungsten Carbide ISO K 05
Cutting speed m/min.	80 – 120
Rake angle	6 – 10°
Clearance angle	7 – 10°
Feed at depth of cut	what ever is choosen
Machining	dry

Milling	Tungsten Carbide ISO K 10 or ISO K 05
Cutting speed m/min.	80 – 100
Rake angle	10°
Clearance angle	12°
Angle of incidence	6°
Setting angle at main tooth	45°
Machining	dry

Grinding	Silicon Carbide Wheels
Hardness	J, K
Grain size	40 – 120
Structure	medium
Binder	ceramic
Cutting speed m/sec.	30
Infeed	max. 0,02 mm
Machining	cooling with soluble oil coolant mixtures

All statements as to the properties or utilization of the materials and products mentioned in this datasheet are only for the purpose of description. Guarantees in respect of the existence of certain properties or utilization at the material mentioned are only valid if agreed upon in writing.