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**COPPER AND COPPER ALLOYS - ROD AND
WIRE FOR WELDING AND BRAZE WELDING**

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Copper and copper alloys - Rod and wire for welding and braze welding

Cuivre et alliages de cuivre - Barres et fils pour soudage et brasage

Kupfer und Kupferlegierungen - Stangen und Drähte für Schweißzusatzwerkstoffe und Fugenlote

This European Standard was approved by CEN on 23 October 2002.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Management Centre has the same status as the official versions.

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Contents

	page
Foreword.....	3
1 Scope	4
2 Normative references	4
3 Terms and definitions.....	4
4 Designations.....	5
4.1 Material.....	5
4.2 Product.....	5
5 Ordering information	6
6 Requirements	6
6.1 Composition	6
6.2 Dimensions and tolerances	7
7 Sampling.....	7
8 Test methods.....	7
8.1 Analysis	7
8.2 Rounding of results	8
9 Declaration of conformity and inspection documentation.....	9
9.1 Declaration of conformity	9
9.2 Inspection documentation	9
10 Marking, labelling, packaging.....	9
10.1 General.....	9
10.2 Marking and labelling	9
10.3 Packaging	9
Table 1 — Composition of copper.....	10
Table 2 — Composition of miscellaneous copper alloys	11
Table 3 — Composition of copper-zinc alloys	12
Table 4 — Composition of copper-tin alloys.....	13
Table 5 — Composition of copper-aluminium alloys	13
Table 6 — Composition of copper-nickel-zinc alloys.....	13
Table 7 — Available diameters and tolerances on diameter (including circularity)	15
Table 8 — Tolerances on length of "nominal length" rod	15
Table 9 — Dimensions of preferred spool sizes.....	16
Table 10 — Maximum masses for wire on spools	17
Table 11 — Sampling rate	17
Bibliography	18

Foreword

This document (EN 13347:2002) has been prepared by Technical Committee CEN/TC 133 "Copper and copper alloys", the Secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2003, and conflicting national standards shall be withdrawn at the latest by June 2003.

Within its programme of work, Technical Committee CEN/TC 133 requested CEN/TC 133/WG 4 "Rod/bar, wire, profiles" to prepare the following standard:

EN 13347, *Copper and copper alloys — Rod and wire for welding and braze welding.*

This is one of a series of European Standards for copper and copper alloy products in rod, wire and profile form. Other products are specified as follows:

EN 12163, *Copper and copper alloys — Rod for general purposes.*

EN 12164, *Copper and copper alloys — Rod for free machining purposes.*

EN 12165, *Copper and copper alloys — Wrought and unwrought forging stock.*

EN 12166, *Copper and copper alloys — Wire for general purposes.*

EN 12167, *Copper and copper alloys — Profiles and rectangular bar for general purposes.*

EN 12168, *Copper and copper alloys — Hollow rod for free machining purposes.*

prEN 13601, *Copper and copper alloys — Copper rod, bar and wire for general electrical purposes.*

prEN 13602, *Copper and copper alloys — Drawn, round copper wire for the manufacture of electrical conductors.*

According to CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

EN 13347:2002 (E)

1 Scope

This European Standard specifies the composition, property requirements and dimensional tolerances for copper and copper alloy rod and wire intended for welding and braze welding purposes.

The sampling procedures, the methods of test for verification of conformity to the requirements of this standard, and the delivery conditions are also specified.

2 Normative references

This European Standard incorporates, by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies (including amendments).

EN 1044, *Brazing — Filler metals*.

EN 1655, *Copper and copper alloys — Declarations of conformity*.

EN 1976, *Copper and copper alloys — Cast unwrought copper products*.

NOTE Informative references to documents used in the preparation of this standard, and cited at the appropriate places in the text, are listed in the bibliography.

3 Terms and definitions

For the purposes of this European Standard, the following terms and definitions apply.

3.1

wire

solid wrought product of uniform circular cross-section along its whole length supplied in coil form or on spools, reels or in drums

3.2

rod

solid wrought product of uniform circular cross-section along its whole length, supplied in straight lengths

3.3

circularity

difference between the maximum and the minimum diameters measured at any cross-section of a round rod or wire

3.4

knurl

embossed finish applied to the surface of the wire or rod to aid the adhesion of subsequently applied flux coatings

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