

## CuSn

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Copper welding wire alloyed with Sn for Mig and Tig welding

**APPLICATIONS** Boilers and tubes out of copper or copper alloys, oven soldering etc..

**PROPERTIES**

- High quality alloyed copper wire
- Sound, pore free deposits and good electrical conductivity
- Excellent corrosion resistance

**CLASSIFICATION**

AWS	A 5.7: ER Cu
EN ISO	24373:
DIN: W.Nr.	2.1006
DIN	1733: SG-CuSn

**SUITABLE FOR** Bronze alloy with minimally 0.8 tin for virtually all welding procedures. Very good deoxidisation. Surfacing and joining of Cu and copper- alloys. Widely used in oven soldering.

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Cu	Mn	Si	Sn	Other
rem	0.3	0.3	0.8	-

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Melting range °C	Hardness HB
				-20°C	-40°C		
AW		220				910-1040	60

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / Drum	kg / pallet
0.8	25-26	80-140	D-200 / KD-300 / Drum	5 / 15 / 250	1080
1.0	26-27	130-200	D-200 / KD-300 / Drum	5 / 15 / 250	1080
1.2	27-28	185-245	D-200 / KD-300 / Drum	5 / 15 / 250	1080
1.6	28-30	250-400	KD-300 / Drum	15 / 250	1080

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I1, I3 Ar/He (70-30)