

CuSn 12

CATEGORY GMAW-GTAW Solid wires

TYPE Tin bronze alloy with high percentage of tin for virtually all welding procedures

PROPERTIES Very good deoxidisation and high hardness similar to cast bronzes.
Surfacing and joining of Copper and CuSn-alloys.
Widely used and recommended for oven soldering.

- High quality alloyed copper wire
- Sound, pore free deposits and good electrical conductivity
- Good corrosion resistance against seawater
- Excelelent sliding properties (bearings etc.)

CLASSIFICATION

AWS	A 5.7: no class
EN ISO	24373:
DIN: W.Nr.	2.1056
DIN	1733: SG-CuSn12

SUITABLE FOR Tin bronze alloy with high percentage of tin for virtually all welding procedures. Very good deoxidisation and high hardness similar to cast bronzes. Surfacing and joining of Copper and CuSn-alloys. Widely used and recommended for oven soldering.

WELDING POSITIONS:



WELD METAL ANALYSIS %

Cu	Sn	Si	P
rem	12.5	-	0.20

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V		Melting range °C	Hardness HB
				-20°C	-40°C		
AW		350				825-990	120

AW: as welded

PARAMÈTRES DE SOUDAGE / EMBALLAGE

D (mm)	Welding Parameters			Packing		
	Voltage (V)	Current (A)	spool type	kg / spool	kg / 1000	
0.8	25-26	80-140	KD-300	15	1080	
1.0	26-27	130-200	KD-300	15	1080	
1.2	27-28	185-245	KD-300	15	1080	

GAS ACC. EN ISO 14175 I1