

CuSn 12 Tig

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
- Excellent corrosion resistance

CLASSIFICATION

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

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APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

Cu	Sn	Si	P	Other
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

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing	
	Current (A) (DC-)		single (kg)	master (kg)
1.6 x 1000	70-150		5	25
2.0 x 1000	100-170		5	25
3.0 x 1000	230-400		5	25

GAS ACC. EN ISO 14175 I1