

## CuSn 6 Tig

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Tin bronze alloy of minimally 6% tin for virtually all welding procedures.

**PROPERTIES** Very good deoxidisation. Surfacing and joining of Copper and CuSn-alloys. Widely used in oven soldering.

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

**CLASSIFICATION**

AWS	A 5.7: ER CuSn-A
EN ISO	24373: Cu 5180A-CuSn6P
DIN: W.Nr.	2.1022
DIN	1733: SG-CuSn6

**SUITABLE FOR** Tin bronze alloy of minimally 6% tin for virtually all welding procedures. Very good deoxidisation. Surfacing and joining of Copper and CuSn-alloys. Widely used in oven soldering.

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Cu	Sn	Si	P	Other
rem	6.3	-	0.20	-

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	Elongation (%)	Impact Energy (J) ISO-V		Melting range °C	Hardness HB
				+20°C	-40°C		
AW		260	20	32		910-1040	80

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
2.4 x 1000	150-200		5	25
3.2 x 1000	230-400		5	25
4.0 x 1000	300-450		5	25
5.0 x 1000	325-500		5	25

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I1