

CuSn Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Copper welding wire alloyed with Sn for 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 _{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		220				910-1040	60

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	100-200		5	25
2.4 x 1000	150-200		5	25
3.2 x 1000	230-400		5	25
4.0 x 1000	350-500		5	25

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1