

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 _{p0,2} (N/mm ²)	R _m (N/mm ²)	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