

CuSn 6

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 +20°C -40°C	Melting range °C	Hardness HB
AW		260	20	32	910-1040	80

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
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
1.6	28-30	250-400	KD-300	15	1080

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1, I3 Ar/He (70-30)