

## CuSn 12

**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

**SUITABLE FOR** Tin bronze alloy with high percentage of tin for virtually all welding procedures. 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.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Cu	Sn	Si	P	Other
rem	12.5	-	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> )	A <sub>5</sub> (%)	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	
	Voltage (V)	Current (A)	spool type	kg / spool	kg / 1000
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

**GAS ACC. EN ISO 14175** I1