

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