

CATEGORY	GTAW Solid wires		
TYPE	Tin bronze alloy with high percentage of tin for virtually all welding procedures		
APPLICATIONS	Boilers and tubes out of copper or copper alloys, oven soldering etc.		
PROPERTIES	Very good deoxidization 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	EN ISO W.Nr.	24373: Cu 5410 / CuSn12P 2.1056	
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	No Approvals Found		

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

P	Zn	Pb	Sn
0.25	0.03	0.01	12

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Brinell Hardness
As Welded /		350		Avg. 120

WELDING PARAMETERS / PACKING

D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING
		CURRENT (A) (DC-)	SINGLE (KG)	MASTER (KG)
1.6 X 1000		70-150	5	25
2.0 X 1000		100-170	5	25
3.0 X 1000		230-400	5	25

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1