

Cu-base solid wire

Classification

AWS A5.7-84R :ERCuSn-A
 EN 14640 :S Cu 5180 (CuSn6P)

General Description

Solid wire for GTAW of copper-tin alloys (bronze)

Shielding gas (acc. EN)

GMAW I1 Inert gas Ar 100%
 I3 Inert gas Ar + > 0-95% He

Chemical composition (w%), typical, all weld metal

| Cu | Sn | P |
|------|----|-----|
| rest | 6 | 0.2 |

Mechanical properties, all weld metal

| | Process | Shielding gas | Condition | 0.2% Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Elongation (%) | Impact (ISO), J +20 °C | Hardness HB |
|------------------------------|--------------|---------------|-----------|--|---------------------------------------|----------------|------------------------|-------------|
| Typical values after welding | GTAW GMAW | I3 | AW | 150 | 260 | 20 | 80 | 75 |

Materials to be welded

| Material grades such as: | Code | Type | W.Nr. |
|--------------------------|-----------|-------------|--------|
| Cu-Sn wrought alloys | DIN 17662 | CuSn4 | 2.1016 |
| | | CuSn6 | 2.1020 |
| | | CuSn8 | 2.1030 |
| Cu-Sn cast alloys | DIN 1705 | G-CuSn2ZnPb | 2.1098 |
| | | G-CuSn5ZnPb | 2.1096 |
| | | G-CuSn6ZnNi | 2.1093 |

Packaging, available sizes and identification

| Process | Unit: | Sizes, mm | | | |
|---------|----------|-----------|-----|-----|-----|
| | | 2.0 | 2.4 | 3.2 | 4.0 |
| GMAW | 2kg tube | X | X | X | X |

Other sizes and packaging on request

Identification

Imprint: Revicu[®]CuSn-6

Tip colour:

Revicu[®]CuSn-6 : rev.EN 20