

Cu-base solid wire

Classification

AWS A5.7-84R :ERCu
 EN 14640 :S Cu 1898 (CuSn1)

General Description

Solid wire for GMAW of copper

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	Mn	Si	Sn	Ni
rest	0.2	0.3	0.8	0.1

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	GMAW	I1	AW	100	220	60		35

Materials to be welded

Material grades such as:	Code	Type	W.Nr.
Copper	DIN 1787	OF-Cu	2.0040
		SE-Cu	2.0070
		SW-Cu	2.0076
		SF-Cu	2.0090
Wrought low alloyed copper alloys	DIN 17666	CuFe2P	2.1310
		CuSP	2.1498
		CuTeP	2.1546

Packaging, available sizes and identification

Process	Unit:	Sizes, mm	
		1.0	1.2
GMAW	12 kg spool B300	X	X

Other sizes and packaging on request

Identification

Imprint: Revicu®CuSn

Tip colour:

Revicu®CuSn : rev.EN 20