AUTOMIG CuSn-A

GMAW COPPER ALLOYS

AWS A/SFA 5.7 **ERCuSn-A**

CLASSIFICATION:

EN ISO 24373
S Cu 5180 (CuSn5P)

KEY FEATURES:

- Copper-Tin solid wire
- Good resistance against corrosion and overheating
- Weld pool should be kept small to reduce hot short cracks
- For thick section, preheating is recommended
- Tin increases the wear resistance of the weld and slows the rate of solidification
- Rapid cooling at room temperature recommended
- Weld deposit easily machinable
- Radiographic quality welds

TYPICAL APPLICATIONS:

- Welding of similar base metals such as 509 to 519 series tin bronze alloys
- Bronze, brass and copper welding
- Overlay welding on steel, casting repair

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

Sn	P	Al	Pb	Cu+Ag
4.0-6.0	0.10-0.35	0.01 max	0.02 max	Bal.

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	Average Brinell Hardness, HBW
Specification	As Welded	240 min	70-85

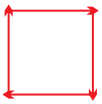
PARAMETERS - PACKING DATA:

Ø x L, mm	Kg/Spool
1.2	12.5
1.6	12.5

DCEP

STORAGE / HANDLING :
Keep dry during storage and handling

All Positions



Shielding Gas	Gas Flow Rate, LPM
75Ar/25He	15-20