

TECHNICAL SHEET



CuSn

Product name

CuSn

Class of product

Cu-Sn alloy wire for MIG / TIG welding.

Corresponding standards

DIN1733 SG-CuSn

Werkstoff nr. 2.10006

BS 2901 P.3 C7

AWS A5.7 ERCu

Composition (weight %)

Cu: balance

Sn: 0,75 – 0,90

Mn: 0,15 – 0,30

P: 0,005 – 0,020

Si: 0,15 – 0,25

Others: 0,5 max

Physical characteristics

Melting range: 1.020 – 1.050 °C

Density: 8,9 g/cm³

Thermal conductivity: 120 – 145 W/m K

Coeff. of linear mean expansion (20-300°C): 18,1 10⁻⁶ 1/K

Electric conductivity: 15 - 20 m/Ω mm²

Resistively: 0,05 – 0,0667 Ω·mm²/mm

Mechanical Properties of welded joint (not treated, standard data)

Tensile strength: 220 N/mm²

Elongation 30 %

Brielle Hardness 60 HB 2,5/62,5

Notched bar impact test 75 Av(J)

Range of application:

Copper-Tin alloy filler metal, with good flow characteristics.

Suitable for joining OF-copper and copper materials subject to high strain.

Easily workable, welding seams without pores are obtained.

For TIG welding of large work pieces preheating is recommended.

Applicable inert gas:

Argon 4.8/5.0/5.3/5.6/6.0

Characteristics Make-up:

Rods: Ø 2,0 6,0 mm Length: 1.000 mm

Wires: Ø 0,8 – 1,0 – 1,2 – 1,6 – 2,4 mm (on spools D300 and wire basket spools)

Other dimensions are available upon request

The above data are subject to change without notice by Spring.

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