MIG CUS

Old reference: MIG Cu110

Classification

AWS A5.7 : ERCu

ISO 24373 : S Cu 1898 (CuSn1)

Description & Applications

Solid wire for GMAW of oxygen free Copper and Cooper alloys. Good flow and porosity free weld seams due to the alloying with Tin. The melting temperature is relatively low and projections are minor.

If a high electrical conductivity is required, use MIG CUAG.

Main appplications: Electrical conductors.

Typical Chemical Composition (%)

	Al	Mn	P	Pb	Si	Sn	O/T	Cu
Min								98.0
Max	0.01	0.50	0.15	0.02	0.50	1.0	0.50	
Type	0.002	0.35	0.01	0.005	0.30	0.80	<0.50	>98.0

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
Min	-	-	-
Max			
Type	50	190	35

Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2	120 - 180 180 - 220 220 - 250	20 - 22 22 - 24 24 - 26	ISO 14175: I1 (100% Ar) I2 (100% He) I3 (Ar+ 5-30%He) 12-18 l/min

Preheating of massive parts between 200°C (>6mm) up to 500°C (>15mm).