



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 applications: 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 | 120 - 180 | 20 - 22 | ISO 14175: I1 (100% Ar) I2 (100% He) I3 (Ar+ 5-30%He) 12-18 l/min |
| | 1.0 | 180 - 220 | 22 - 24 | |
| | 1.2 | 220 - 250 | 24 - 26 | |

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

FT En-MU01-200211

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group.

Fumes: Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr