



MIG CUS13

Old reference: MIG CuSn13

Classification

ISO 24373 : S Cu 5410 (CuSn12P)

Description & Applications

Solid wire for GMAW of Copper-Tin bronzes as well as for Copper-Tin castings.

Main applications: Harfacing of wear surface, repair of Copper-Tin casting.

Typical Chemical Composition (%)

	Al	P	Pb	Sn	Zn	O/T	Cu
Min		0.01		11.0			
Max	0.005	0.4	0.02	13.0	0.05	0.4	Rem.
Type	0.001	0.20	0.005	12.5	0.008	<0.4	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max			
Type		320	5

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-MU04-200213

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Fumes: Consult information on MSDS, available upon request.

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