MIG CUS6

Old reference: MIG Cu114

Classification

AWS A5.7 : ~ERCuSn-A ISO 24373 : S Cu 5180A (CuSn6P)

Description & Applications

Solid wire for GMAW of Copper and similar Copper-Tin alloys.

Main applications: Surfacing of wearing surfaces, repair of Tin-Copper alloy and Brass alloy.

Base materials:

UNS	DIN	Material N°
C50700	CuSn2	2.1010
C51100	CuSn4	2.1016
C51900	CuSn6	2.1020
C52100	CuSn8	2.1030
	CuSn6Zn	2.1080
C52400	G-CuSn10	2.1050

Typical Chemical Composition (%)

	Al	Fe	P	Pb	Sn	Zn	O/T	Cu
Min			0.01		4.0			
Max	0.01	0.1	0.4	0.02	7.0	0.1	0.2	Rem.
Type	0.003	0.01	0.15	0.0005	6.2	0.02	<0.2	Rem.

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
Min	-	-	-
Max			
Type	150	300	20

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).

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