



# 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 <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
Min	-	-	-
Max			
Type	150	300	20

## 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-MU02-200212

**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](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)