



MIG CUS8

Old reference: MIG CuSn8

Classification

ISO 24373 : S Cu 5210 (CuSn8P)

Description & Applications

Solid wire for GMAW of Copper-Tin bronzes alloys.

Main applications: For surfacing of wearing surfaces and welding of galvanized sheets.

Typical Chemical Composition (%)

	Fe	Ni	P	Pb	Sn	Zn	O/T	Cu
Min			0.01		7.5			
Max	0.1	0.2	0.4	0.02	8.5	0.2	0.2	Rem.
Type	0.001	0.001	0.08	0.002	8.0	0.008	<0.2	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max			
Type		260	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).

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Fumes: Consult information on MSDS, available upon request.

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