



TIG CUS

Old reference: TIG Cu110

Classification

AWS A5.7 : ERCu

ISO 24373 : S Cu 1898 (CuSn1)

Description & Applications

Solid rod for GTAW 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 TIG 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

Welding mode	Shielding Gas
GTAW = -	ISO 14175: I1 (100% Ar) / I2 (100% He) / I3 (Ar+ 5-30%He) 5-10 L/min

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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