



TIG CUS13

Old reference: TIG CuSn13

Classification

ISO 24373 : S Cu 5410 (CuSn12P)

Description & Applications

Solid rod for GTAW 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

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).

FT En-TUI04-170220

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Fumes: Consult information on MSDS, available upon request.

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