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| Technical data sheet <small>011121MBA</small> | Copper base – Solid wire WA TCU/MCU Sn6 |  Welding Alloys |
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CLASSIFICATION

ASME IIC SFA 5.7 / AWS A 5.7: ERcuSn-A
EN ISO 24373: S Cu 5180 (CuSn5P)

DESCRIPTION

- GTAW rod / GMAW copper base solid wire
- Deposits a 6% tin bronze

APPLICATIONS

- Joining and surfacing Cu-Sn (bronze), Cu-Zn (brass) and Cu-Sn-Zn-Pb alloys
- Surfacing of cast irons or C-Mn steels

TYPICAL WIRE ANALYSIS [weight %]

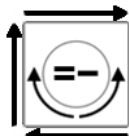
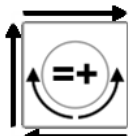
| Cu | Sn | P |
|------|-----|-----|
| Bal. | 5.6 | 0.2 |

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

| Rm [MPa] | Rp0.2[MPa] | A5 [%] |
|----------|------------|--------|
| 300 | 150 | 20 |

All-weld metal hardness: 80 HB
Thermal conductivity: 75 W/m*K

SHIELDING GAS – OPERATING CONDITIONS – WELDING POSITIONS

| GTAW | | GMAW | |
|---|---|---|---|
| Shielding gas according to EN ISO 14175 | Welding positions Current type | Shielding gas according to EN ISO 14175 | Welding positions Current type |
| I1 (100 % argon) |  | I1 (100 % argon) I3 (e.g : Ar + 30 % He) |  |

Preheating at 250°C is mandatory for wall thicknesses exceeding 6 mm.
Pulsed current mode is recommended for surfacing on iron base materials.

PACKAGING

| Spools | Ø mm | 0.8 | 1.0 | 1.2 | 1.6 | |
|--------|------------|-----|-----|-----|-----|-----|
| Rods | Ø x1000 mm | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 |

Other dimensions on request

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.