



MIG CUS

Old reference: MIG Cu110

Classification

ISO 24373 : S Cu 1898 (CuSn1)

AWS A5.7 : ERCu

Description & Applications

Wire electrode for MIG welding of oxygen free Copper and copper 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 MIG CuAg.

Typical Chemical Composition (%)

| Sn | Mn | Si | P | Cu |
|-----|-----|-----|------|------|
| 0.8 | 0.4 | 0.2 | 0.01 | Rem. |

All Weld Metal Mechanical Properties

| $R_{p0.2}$ (MPa) | R_m (MPa) | A_5 (%) |
|--------------------|---------------|-------------|
| 50 | 190 | 35 |

Welding Current & Instructions

| Welding mode | Wire Ø (mm) | Welding parameters | | Shielding Gas |
|--------------|-------------|--------------------|-----|---------------|
| | | Pulsed arc (A) | (V) | |
| MIG = + | | | | Ar Ar + He |

Preheating at about 400°C is advised for massive parts, thickness > 3mm.

Ind.10



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