



MIG CUS6

Old reference: MIG Cu114

Classification

ISO 24373 : S Cu 5180 (CuSn5P) Material N° : 2.1022
 AWS A5.7 : ERCuSn-A

Description & Applications

Solid wire for GMAW used for joining and repairing of copper and similar copper tin alloys. Surfacing of friction surfaces. Welding of zinc coated sheets.

Base materials

UNS	DIN	Material N°
C50700	CuSn2	2.1010
C51100	CuSn4	2.1016
C51900	CuSn6	2.1020
C52100	CuSn8	2.1030
	CuSn6Zn	2.1080
C52400	G-CuSn10	2.1050

Typical Chemical Composition (%)

Sn	P	Pb	Cu
6.0	0.2	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
150	300	20

Welding Current & Instructions

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

Ind.10



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