



TIG CUS6

Old reference: TIG Cu114

Classification

ISO 24373 : S Cu 5180 (CuSn6P) Material N° : 2.1022
 AWS A5.7 : ER CuSn-A

Description & Applications

Solid rod for TIG welding and repairing of copper and similar copper tin alloys. Welding of zinc coated sheets. Surfacing of friction surfaces.

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	Shielding Gas
TIG = -	Ar : 5-10 l/min Argon / He : 5-10 l/min

ind.10



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.