

## GSM-MIG CuSn6

## GSM-WIG CuSn6

### Classification:

DIN EN ISO 24373: S Cu 5180 AWS A 5.7: ERCuSn-A	DIN 1733: SG-CuSn6 Material Nr.: 2.1022	DIN EN ISO 24373: S Cu 5180 AWS A 5.7: ERCuSn-A	DIN 1733: SG-CuSn6 Material Nr.: 2.1022
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### General Description:

Copper-tin alloys, e.g. bronze with 4 - 8% Sn, copper-zinc alloys (brass), copper-tin-zinc-lead cast alloys (CuSnZnPb), build-up welds on cast iron. GSM-MIG/WIG CuSn6 is suited for joint of brass-brass or brass-Cu alloys, brass-cast iron, overheating- and corrosion-resistant tin-bronze alloys and MIG-brazing of galvanised steels. Very good deoxidisation and good electrical conductivity.

For wall thicknesses over 6.00 mm, preheating to + 250 °C is required.

MIG - Pulse arc welding is recommended for build-up welding on ferrous materials.

TIG - For build-up welding on ferrous materials, introduce as much filler material as possible into the arc.

### Base Materials

2.01010	2.1030	2.1056	2.1090	2.1491
2.1016	2.1050	2.1080	2.1096	
2.1020	2.1052	2.1086		

### Chemical Composition (W%), Typical, All Weld Metal

Cu	Sn	P
Bal.	6,0	0,2

### Mechanical Properties, Typical, All Weld Metal

Streckgrenze $R_{el}$ [ $\frac{N}{mm^2}$ ]	Festigkeit $R_m$ [ $\frac{N}{mm^2}$ ]	Dehnung $A_5$ [%]	Kerbschlagarbeit $K_v$ [J]	Härte [HB]
MIG: 140 TIG: 150	MIG: 300 TIG: 260	20		80

Electrical conductivity: 7-9 [Sm/mm<sup>2</sup>]

Heat conductivity: 75 [W/m.K]

Melting range: 910-1040 °C

### Processing instructions

Welding Positions MIG / TIG	Shielding Gas	Polarity MIG/TIG
PA, PB, PF / PA, PB, PC, PE, PF	I1	MIG: DC+/ TIG: DC-

### Available Sizes

MIG Spools		TIG Rods	
Diameter (mm)	Article No.	Diameter x Length (mm)	Article No.
0,8	412-2708	1,6 x 1000	409-1216
1,0	412-2710	2,0 x 1000	409-1220
1,2	412-2712	2,4 x 1000	409-1224
		3,0 x 1000	409-1230

