

ML CuSn

Rod/Wire electrode for Copper

Typical composition in %	Al < 0,01 Si 0,10-0,40 Mn 0,10-0,40 Ni (einschl. Co) < 0,10 Sn 0,50-1,00 Pb < 0,01 Fe < 0,03 P < 0,015 Others total < 0,20
Classification	ISO 24373 S Cu 1898A (CuSn1MnSi) DIN 1733 SG-CuSn Material No. 2.1006 BS 2901 part 3 C 7 AWS A 5.7 ER Cu
Base materials	OF-Cu; SE-Cu; SW-Cu; SF-Cu; CuZn0,5
Remarks	Filler wire for joining of high-duty copper materials. Excellent weldability. High quality welds without porosity for applications in construction and for pressure vessels.
Physical properties (Approx. values)	Electrical conductivity [S*m/mm ²] 15-20 Density [kg/dm ³] 8,9 Solidus-Temperature [°C] 1020 Liquidus-Temperature [°C] 1050 Tensile strength R _m [MPa] 210-245 Hardness [HB] 60-80
Welding position	PA, PB, PC, PE, PF
Shielding gas	I1, I2, I3 (Argon, Helium or Argon/Helium-mixtures)
Polarity	MIG =+, TIG -
Dimensions Ø	MIG-wires [mm] 0,8; 1,0; 1,2; 1,6; 2,0; 2,4; 3,2 TIG-rods [mm] 1,6; 2,0; 2,4; 3,2; 4,0
Wire packagings	Spools Packaging units S 300 / 15 kg 25 spools = 375 kg (pallet) B 300 / 3 kg n/a B 300 / BS 300 / 15 kg 25 spools = 375 kg (pallet) Eco-drum / 200 kg 2 drums = 400 kg (pallet)
Rod packagings	Box 10 kg Length 1.000 mm