

# FONTARGEN A 203/6 W

## Copper-tin welding rod



ISO 24373:	S Cu 5180 (CuSn6P)
AWS A 5.7:	ERCuSn-A
Material-no.:	2.1022

### Composition, typical analysis (% w/w):

Sn	P	Cu
6	0.2	Remainder

### Characteristics / Applications:

Welding of copper materials, e.g. copper and Sn bronze. Particularly well suited for joint welding of brass on brass or brass on other Cu alloys, (Rg), Fe materials and cast iron. Other applications include: Building-up of bearing bushes, sliding rails and repairs of tin bronze parts. For tin bronze parts of more than 8 mm thickness we recommend preheating. Suitable for material numbers: 2.1010, 2.1016, 2.1020, 2.1030, 2.1050, 2.1052, 2.1056, 2.1080, 2.1086, 2.1090, 2.1096.

Corrosion- and overheating-resistant tin-bronze alloy. A 203/6 W is very easily machined and produces a clear weld pool. The welding deposit is tough and non-porous.

### Mechanical properties of pure welding deposit

#### (Min. values at room temperature):

Melting range:	910 - 1040 °C
Tensile strength:	330 N/mm <sup>2</sup>
Elongation (l=5d):	30 %
Hardness (Brinell):	80 HB
Electrical conductivity:	7 - 9 Sm/mm <sup>2</sup>
Thermal conductivity:	75 W/m • K
Linear expansion:	18.5 • 10 <sup>-6</sup> /K

**Welding process:** TIG, gas welding

**Shielding gas (DIN EN 439):** I 1 (Argon)

**Current mode:** DC (-pole)

**Availability:** Diameter (mm): 1.6/2.0/2.4/3.2/4.0  
Length (mm): 1000

**Welding position:** according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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