FONTARGEN A 203/6 M

Copper-tin wire electrode for MIG-welding

ISO 24373:	S Cu 5180 A (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. CuSn-alloys, CuSnZnPb-cast alloys. Particularly well suited for the joint welding of brass on brass or brass on Cu-alloys, Fe-materials and cast iron. Suitable for welding of galvanised steel (MIG-brazing). Further applications include: Building-up of bearing bushes, sliding rails, repairs of phosphor bronze parts. For tin-bronze parts of > 10 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. Build-up welding on Fe materials should be performed by pulsed arc welding.

Corrosion- and overheating-resistant tin-bronze alloy. A 203/6 M is very easily machined and produces a clear weld pool. The welding deposit is tough and non-porous. Keep arc short. To eliminate contraction strains (in materials with high tin content) peen the seam.

Mechanical properties of pure welding deposit (Min. values at room temperature):

Melting range:	910 - 1040 °C
Tensile strength:	260 N/mm²
Elongation (l=5d):	20 %
Thermal elongation:	18.1 • 10^{-6}/K
Hardness (Brinell):	80 HB
Electrical conductivity:	6 - 7 Sm/mm²
Heat conductivity:	75 W/m • K
Specific gravity:	8.7 g/cm³
Welding process:	MIG
Shielding gas (DIN EN 439):	I 1 (Argon)
Current mode:	DC (+pole)
Availability:	Diameter (mm): 0.8/1.0/1.2/1.6/2.0/2.4
Spool type:	B300, S300
Welding position:	according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
☒	☒	☒	☐	☒	☒	☐

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