



CLASSIFICATIONS

EN ISO 24373	AWS A5.7
S Cu 5180A (CuSn6P)	ERCuSn-A

KEY FEATURES AND APPLICATIONS

- Solid copper-tin wire used for build-up and joining of CuSn alloys, CuSnZnPb cast alloys and cast iron.
- Offers excellent corrosion resistance and very good deoxidization.
- Depending on the base material thickness, preheating may be required.
- Typically used on electric and heat conductor parts, i.e. oven soldering etc.

BASE MATERIALS

2.1010, 2.1016, 2.1020, 2.1030, 2.1050, 2.1052, 2.1056, 2.1080, 2.1086, 2.1090, 2.1096
CuSn8, CuSn7, CuSn6, CuSn4, G-CuSn7ZnPb, G-CuSn10

CHEMICAL COMPOSITION OF WIRE %

	Cu	Al	Fe	Pb	Si	Sn	Zn	Others
MIN	Bal.	-	-	0.01	-	4.0	-	0.2
MAX		0.01	0.1	0.45	0.02	7.0	0.1	

Single values are maximum values according to EN ISO 24373 unless otherwise stated

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Tensile Strength (MPa)	Hardness (HB)	Melting Temperature
≥240	70 - 85	910 - 1040°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1, I3	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP40331	1.6	1000	5	PAP 20 Tube
XP40332	2.4	1000	5	PAP 20 Tube
XP40333	3.2	1000	5	PAP 20 Tube