

Cu-base solid wire

Classification

AWS A5.7-84R : ERCu
DIN 1733-88 : SG-CuSn

General description

Solid wire for GMA-welding of copper

Shielding gases (acc. EN 439)

GMAW I1 Inert gas Ar (100%)
I3 Inert gas Ar+ >0-95% He

Approvals

Chemical composition (w%), typical, wire

Cu	Mn	Si	Sn	Ni
bal.	0.2	0.3	0.8	0.1

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Hardness HB
Typical values	GMAW	I1	AW	100	220	60	35

Materials to be welded

Material	Code	Type	W.Nr.
Copper	DIN 1787	OF-Cu	2.0040
		SE-Cu	2.0070
		SW-Cu	2.0076
		SF-Cu	2.0090
Wrought low alloyed copper alloys	DIN 17666	CuFe2P	2.1310
		CuSP	2.1498
		CuTeP	2.1546

Packaging

Process	Unit	Sizes (mm)	
		1.0	1.2
GMAW	12 kg spool B300	X	X

Other sizes and packaging on request

LNM CuSn: rev. EN 15