



# CEWELD CuSn

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |                      |        |          |
|---------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------|----------|
| TYPE                                              | Copper welding wire alloyed with Sn for Mig and Tig welding                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         |                      |        |          |
| APPLICATIONS                                      | Boilers and tubes out of copper or copper alloys, oven soldering etc..                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |        |          |
| PROPERTIES                                        | <div>• High quality alloyed copper wire • Sound, pore free deposits and good electrical conductivity</div> <div>• Excellent corrosion resistance</div>                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |        |          |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | A 5.7: ERCu             |                      |        |          |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 24373: Cu 1898 / CuSn1  |                      |        |          |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | ~2.1006                 |                      |        |          |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 31                      |                      |        |          |
| SUITABLE FOR                                      | Bronze alloy with minimally 0.8 tin for virtually all welding procedures. Very good deoxidisation. Surfacing and joining of Cu and copper- alloys. Widely used in oven soldering.<br>2.0040 - OF-Cu,<br>2.0070 - SE-Cu,<br>2.0076 - SW-Cu,<br>2.0090 - SF-Cu                                                                                                                                                                                                                                                                                                                                    |                         |                      |        |          |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |                      |        |          |
| WELDING POSITIONS                                 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> |                         |                      |        |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Mn                      | Cu                   | Sn     |          |
|                                                   | 0.3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 0.3                     | 98.5                 | 0.8    |          |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         | 220                  |        | 60 HB    |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                         |                      |        |          |
| GAS ACC. EN ISO 14175                             | I1, I3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |        |          |



# CEWELD CuSn

CUSN 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| D-300     | 15      | 8720663408624 |

CUSN 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663408631 |

CUSN 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663408648 |
| Drum      | 250     | 8720682051528 |

CUSN 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663408655 |