

LNM CuSn6

CLASSIFICATION

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

GENERAL DESCRIPTION

Solid wire for welding of copper-tin alloys

WELDING POSITIONS



SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)
I3 Inert gas Ar+ 0.5-95% He

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

Cu	Sn	P
bal.	6.0	0.2

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2 proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	I1	AW	150	260	20	80

EXAMPLES OF MATERIALS TO BE WELDED

Cu-alloy grades	Standard	Type	Mat. Nr
Copper-tin wrought alloys			
	DIN 17662	CuSn4	2.1016
		CuSn6	2.1020
		CuSn8	2.1030
Copper-tin cast alloys			
	DIN 1705	G-CuSn2ZnPb	2.1098
		G-CuSn5ZnPb	2.1096
		G-CuSn6ZnNi	2.1093

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2	1.6
Unit : 15 kg spool B300	X	X	X

Other sizes and packaging on request

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