

MCU SN

Gas Metal Arc (MIG) Welding Wire - Copper Alloys

Standards

AWS/ASME SFA - 5.7	ERCu
EN ISO 24373	S Cu 1898 (CuSn1)
TS EN ISO 24373	S Cu 1898 (CuSn1)
DIN M. No.	2.1006

Properties and Applications

Tin alloyed copper wire electrode for GMA (MIG) welding of copper and low alloyed copper alloys. Particularly used in electric and heat conductor parts, which are made of pure copper. Suitable for welding oxygen-free copper and copper materials subject to high strain. Gives pore-free and easily machinable welding seams.

Materials

DIN	Material	ASTM
OF-Cu	2.0040	C10100
E-CU	2.0060	C11000
SE-Cu	2.0070	C10300
SW-Cu	2.0076	
SF-Cu	2.0090	C12200
SB Cu	2.0150	C14200

Typical Chemical Features of the Welding Wire

Type of Analysis	Si	Mn	P	Cu	Sn
Welding Wire	0.20	0.20	0.01	98.79	0.80

Typical Physical Analysis of the Weld Metal

Özgül Ağırlığı (gr/cm ³)	Elektrik İletkenliği (Sm/mm ²)
0.00	0.05-0.07

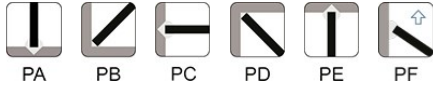
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Hardness (HB)
As welded	I1	100	220	30	60

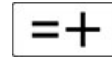
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:
I3 I1 I2

Welding Parameters & Efficiency

Diameter (mm)
1.00
1.20
1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
25000DHAM2	1.00	15 kg	15.80	1	15.80	Plastic Spool (D300)
25000EHAM2	1.20	15 kg	15.80	1	15.80	Plastic Spool (D300)
25000GHAM2	1.60	15 kg	15.80	1	15.80	Plastic Spool (D300)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.