

MCU SN6

Gas Metal Arc (MIG) Welding Wire - Copper Alloys

Standards

AWS/ASME SFA - 5.7	~ERCuSn-A
EN ISO 24373	S Cu 5180A (CuSn6P)
TS EN ISO 24373	S Cu 5180A (CuSn6P)
DIN M. No.	2.1022

Properties and Applications

6% Tin alloyed copper wire electrode for GMA (MIG) welding and surfacing of Cu-Sn (4 - 8 % Sn bronze), Cu-Zn (brass), and Cu-Sn-Zn-Pb alloys. Suitable for joining of copper alloys to steels, repair welding of cast bronzes and cladding on cast iron and steels. For large workpieces e.g. thicknesses exceeding 5 mm, a preheat at about 250°C is recommended.

Materials

DIN	Material	ASTM
Cu Sn 2	2.1010	C50700
Cu Sn 4	2.1016	C51100
Cu Sn 6	2.1020	C51900
Cu Sn 8	2.1030	C52100
G-Cu Sn 10	2.1050	C52400
Cu Sn 6 Zn	2.1080	
G-Cu Sn 7 Zn Pb	2.1090	
G-Cu Sn 6 Zn Ni	2.1093	
G-Cu Sn 5 Zn Pb	2.1096	

Typical Chemical Features of the Welding Wire

Type of Analysis	P	Cu	Sn
Welding Wire	0.20	93.30	6.50

Typical Physical Analysis of the Weld Metal

Özgül Ağırlığı (gr/cm ³)	Elektrik İletkenliği (Sm/mm ²)
0.00	0.14-0.17

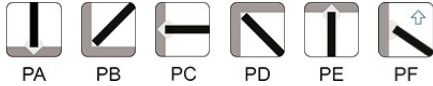
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Hardness (HB)
As welded	I1	160	260	20	80

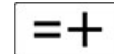
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I3 I1 I2

Welding Parameters & Efficiency

Diameter (mm)
1.00
1.20

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
25001DHAM2	1.00	15 kg	15.80	1	15.80	Plastic Spool (D300)
25001EHAM2	1.20	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.