

CARBO S- CuSn

CARBO T- CuSn

International standards

	S = solid wire	T = bare rod
Material No.	2.1006	
DIN 1733	SG - CuSn	SG - CuSn
AWS A 5.7	ER Cu	ER Cu

Approvals

Application notes

Cu base wire electrode for joints and platings on Cu and Cu-alloys. Preheating is necessary for sections thicker than 3 mm (100°C for each mm, 600 °max.). In case of more than 300°C preheating temperature borium containing flux addition is necessary. Preheating temperature of pure copper: 400-600°C.

Base material

2.0040, 2.0070, 2.0076, 2.0090, 2.0205

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO – V J at Rt.° C
220	100	>30	70

Hardness

50 HB

Weld metal analysis

(typical, wt %)

Cu	Mn	Sn	Si
Base	0,30	0,80	0,30

Gas types EN 439

S = solid wire

I1-I3

T = bare rod

I1

Current

Diameter mm
Welding amps (A) min.
(A) max.

= +				= -				
0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0

coils, weight

Rev. 001/13

B300 15 kg.

10 kg./ carton