CARBO S- CuSn
CARBO T- CuSn

International standards

	S = massive wire	T = bare rod
Werkstoff Nr.	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 than3 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.
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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/mm²	Yielding strength $R_{p0,2}$ N/mm²	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

	S = massive wire	T = bare rod
Gas types EN 439	I1-I3	I1

Current

		S = massive wire = +				T = bare rod = –				
Diameter	mm	**0,8**	**1,0**	**1,2**	**1,6**	**1,6**	**2,0**	**2,4**	**3,2**	**4,0**
Welding amps	(A) min.									
	(A) max.									

coils, weight B300 15 kg. 10 kg./ carton

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.