



DESCRIPTION

Tin bronze alloy solid wire

High tin alloyed bronze to weld bronze of similar composition; very often used to join copper with steel. Used for cast iron hardfacing. Suitable to weld CuSn alloys, CuSnZnPb cast alloys and cast iron. For GMAW brazing on steel it is recommended to use a pulsed arc. Excellent for artistic foundries.

SPECIFICATIONS

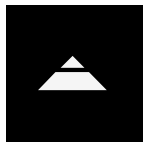
AWS A5.7	ERCuSn-A	DIN 1733	SG- CuSn6
Certifications	-	Shielding	I1, I3
Positions	PA, PB, PC, PD, PE, PF, PG	Current	DC+
Packaging Type	Drums, B300, D200 and D100 spools.		

ASME QUALIFICATIONS		FERRITE	PREN	HARDNESS
F-No (QW432)	33	-	-	80HB
A-No (QW442)	-			

CHEM. COMP. %	DEFAULT	MECHANICAL PROPERTIES	MIN	VARIANT
Mn	0.25	Tensile strength R _m MPa	240	250
Al	0.001	Yield strength R _{p0.2} MPa	-	130
Sn	6.5	Elongation A (L ₀ =5d ₀) %	0	20
P	0.01	Impact Charpy ISO-V	-	-
Si	0.1	Impact Charpy ISO-V	-	-
Fe	0.01			
Zn	0.01			
Pb	0.01			

WELDING PARAMETERS		1 mm	1.2 mm
Ampere		130A - 200A	185A - 245A
Voltage		24V - 28V	26V - 30V
Packaging		Ø 0,8÷1,6mm	Ø 0,8÷1,6mm
Packaging Type		Drums, B300, D200 and D100 spools.	Drums, B300, D200 and D100 spools.





CuSn

DESCRIPTION

COPPER ALLOYS

CuSn

APPLICATION

Used for welding various copper-based alloys to themselves, CMn steels, or cast irons, and for repairing and joining castings, this consumable is also suitable for weld surfacing to provide a bearing surface and/or corrosion-resistant overlay on steel components, shafts, etc. Avoiding stainless steels is recommended due to chromium pick-up causing embrittlement. The tin bronze weld metal can be sluggish due to its wide melting range. Preheating to approximately 200°C can enhance fluidity when dealing with thick sections. To prevent hot cracking, it's advisable to maintain the interpass temperature below 200°C. This consumable is also applicable for welding copper materials if the presence of tin in the weld metal is acceptable, such as in copper and tin bronzes, particularly for joining copper-zinc alloys and steels. For multi-layer welding on steel, pulsed arc welding is advised, and it is also suitable for oven soldering.

ALLOY TYPE

Tin bronze alloy wire for welding similar tin bronze (phosphor bronze) alloys.

MICROSTRUCTURE

A multi phase copper base structure with complex eutectoids.

MATERIALS

Tin bronze up to 10%Sn+0.5%P. Cu + 20-25%Sn. Cu + 40%Zn, manganese bronze.

V 01/2024



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.

 **DAIKO**