

FONTARGEN A 200 SW

Copper-tin welding rod



ISO 24373: S Cu 1898 (CuSn1)
AWS A 5.7: ERCu
Material-no.: 2.1006

Composition, typical analysis (% w/w):

| Sn | Si | Mn | P | Cu |
|-----|-----|-----|------|-----------|
| 0.8 | 0.3 | 0.3 | 0.01 | Remainder |

Characteristics / Applications:

Joint and build-up welding on copper and copper alloys of material numbers: 2.0040, 2.0060, 2.0070, 2.0080, 2.0090, 2.0100, 2.0120, 2.0150, 2.0170, 2.1202, 2.1322, 2.1325, 2.1491. Suitable for copper pipe installations according to DVGW work sheet GW 2. The base materials in the welding spheres should be cleaned and preheated if over 3 mm (per mm of plate thickness approx. 100 °C, but not over 600 °C). For preheating temperatures of over 300 °C, flux should be used.

Mechanical properties of pure welding deposit (Min. values at room temperature):

Melting range: 1020 - 1050 °C
Tensile strength: 200 N/mm²
Elongation (l=5d): 30 %
Hardness (BHN): 60 HB
Impact energy: 75 J
Heat conductivity: 120 - 145 W/m • K
Electrical conductivity (20 °C): 15 - 20 Sm/mm²
Thermal elongation: 18 • 10⁻⁶/K

Welding process: TIG, gas welding

Shielding gas (DIN EN 439): I 1 (Argon)
I 3 (Argon/Helium mixture)

Flux: F 100 (Paste) at preheating > 300 °C

Current mode: DC (-pole)

Availability: Diameter (mm): 1.6/2.0/2.4/3.2
Length (mm): 1000

Welding positions: according to DIN EN 287

| PA | PB | PC | PD | PE | PF | PG |
|-------------------------------------|-------------------------------------|-------------------------------------|--------------------------|-------------------------------------|-------------------------------------|--------------------------|
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