FONTARGEN A 200 SW



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

Composition, typical analysis (% w/w):

Sn	Si	Mn	Р	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

(with, values at room temperatu	ire):
Melting range:	1020 - 1050 °C
Tensile strength:	200 N/mm ²
Elongation (I=5d):	30 %
Hardness (BHN):	60 HB
Impact energy:	75 J
Heat conductivity:	120 - 145 W/m • K
Electrical conductivity (20 °C):	15 - 20 Sm/mm ²
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
Walden a setter as	according to DIN EN 207

Welding positions:

according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
\boxtimes	\boxtimes	\boxtimes		\boxtimes	\boxtimes	

13/11/JL/1

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