### FONTARGEN A 202 W

Copper-silicon welding rod



ISO 24373:	S Cu 6560 (CuSi3Mn1)
AWS A 5.7:	ERCuSi-A
Material-no.:	2.1461

#### Composition, typical analysis (% w/w):

Si	Sn	Zn	Mn	Fe	Cu
2.9	0.1	0.1	1	0.1	Remainder

#### **Characteristics / Applications:**

High temperature- and corrosion resistance as well as good behaviour to compression stress. Thanks to high silicon content liquid welding deposit that results in flat seams.

Joint and build-up welding on copper alloys of material numbers 2.0853, 2.0855, 2.0857, 2.1243, 2.1245, 2.1247, 2.1265, 2.1266, 2.1267, 2.1270, 2.1285, 2.1322, 2.1323, 2.1363, 2.1366, 2.1522, 2.1525, 2.1545, 2.1546, brass as well as build-up welding on unalloyed or low-alloyed steels and cast iron. To avoid hot cracks keep welding pool small and feed fast. Preheat thick workpieces to 350 - 600 °C.

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

(	
Melting range:	910 - 1025 °C
Tensile strength:	350 N/mm²
Yield strength (0.2 %):	120 N/mm <sup>2</sup>
Elongation (I=5d):	40 %
Thermal elongation:	18 • 10⁻⁶/K
Hardness (Brinell):	85 - 100 HB
Electrical conductivity:	3 - 4 Sm/mm <sup>2</sup>
Heat conductivity:	35 W/m • K
Specific gravity:	8.5 g/cm <sup>3</sup>
Welding process:	TIG
Shielding gas (DIN EN 439):	I 1 (Argon)
Current mode:	DC (-pole)
Availability:	Diameter (mm): 1.6/2.0/2.4/3.2 Length (mm): 1000
Walding a selfier.	DIN EN 007

# Welding position: according to DIN EN 287 PA PB PC PD PE PF Image: Image of the second secon

13/11/JL/1

All information concerning our products, equipment and processes is based on extensive research work and application technology experience. We provide these results orably and in writing in all conscience, this not however exempting the constance from the obligation to benefit our product and an processes on the source responsibility, especially if the application and process has not been expressly approved by us in writing. The test certificates enclosed do not exempt the user from carrying out correct incombility, especially if the application and process has not been expressly approved by us in writing. The test certificates enclosed do not exempt the user from carrying out correct incombility, especially and in with Sections 37773476 (Bergerma contracted) and 11 of our Gereant Terms of Sale and Delivery have valify of any damaging events.