

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/mm²
Elongation (l=5d): 40 %
Thermal elongation: 18 • 10⁻⁶/K
Hardness (Brinell): 85 - 100 HB
Electrical conductivity: 3 - 4 Sm/mm²
Heat conductivity: 35 W/m • K
Specific gravity: 8.5 g/cm³

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

Welding position: according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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