

FONTARGEN A 203/12 M

Copper-tin wire electrode for MIG-welding



ISO 24373:	S Cu 5410 (CuSn12P)
AWS A 5.7:	RCuSn-D
Material-no.:	2.1056

Composition, typical analysis (% w/w):

Sn	P	Cu
12	0.2	Remainder

Characteristics / Applications:

Welding of copper materials, e.g. copper and Sn-bronze. Particularly well suited for joint welding of brass on brass or brass on Cu alloys and Fe materials. Building-up of bearing bushes, sliding rails and repairs of phosphor bronze parts. Welding deposit nearly of same colour as welding of red brass Rg 5. Suitable for material numbers: 2.1010, 2.1020, 2.1050, 2.1056, 2.1086, 2.1016, 2.1030, 2.1052, 2.1080. Build-up welding on Fe materials should be performed with pulsed arc welding.

Corrosion- and overheating-resistant tin-bronze alloy. A 203/12 M is very easily machined and produces a clear weld pool that is smooth, clear and non-porous.

Mechanical properties of pure welding deposit

(Min. values at room temperature):

Melting range:	825 - 990 °C
Tensile strength:	320 N/mm ²
Elongation (l=5d):	5 %
Thermal elongation:	18.5 • 10 ⁻⁶ /K
Hardness (Brinell):	120 HB
Impact energy:	8 J
Electrical conductivity:	3 - 5 Sm/mm ²
Heat conductivity:	40 - 50 W/m • K
Specific gravity:	8.6 g/cm ³

Welding process: MIG

Shielding gas (DIN EN 439): I 1 (Argon)

Current mode: DC (+pole)

Availability: Diameter (mm): 0.8/1.0/1.2/1.6/2.0/2.4

Spool type: B300
S300

Welding position: according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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