

FONTARGEN A 203/12 W

Copper-tin welding rod

ISO 24373:	S Cu 5410 (CuSn12P)
AWS A 5.13:	ERCuSn-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 or brass on Cu alloys and Fe materials. Building-up of bearing bushes, sliding rails and repairs of phosphor bronze parts. Welding deposit very similar coloured as welding of red brass Rg 5. Suitable for material numbers: 2.1020, 2.1050, 2.1056, 2.1086, 2.1016, 2.1030, 2.1052, 2.1080.

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 %
Hardness (BHN):	120 HB
Heat conductivity:	40 - 50 W/m • K
Electrical conductivity (20 °C):	3 - 5 Sm/mm ²
Linear expansion:	18.5 • 10 ⁻⁶ /K
Specific gravity:	8.6 kg/dm ³

Welding process: TIG, gas welding

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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