

# 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<sup>2</sup>  
Elongation (l=5d): 5 %  
Hardness (BHN): 120 HB  
Heat conductivity: 40 - 50 W/m • K  
Electrical conductivity (20 °C): 3 - 5 Sm/mm<sup>2</sup>  
Linear expansion:  $18.5 \cdot 10^{-6}/K$   
Specific gravity: 8.6 kg/dm<sup>3</sup>

**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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