

# FONTARGEN A 207 M

## Cu-Si-Mn wire electrode for MIG-Brazing



ISO 24373: S Cu 6511 (CuSi2Mn)  
Material-no.: 2.1522

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

Si	Sn	Mn	Cu
1.8	0.2	1	Remainder

### Characteristics / Applications:

Very easy to weld. High temperature- and corrosion resistance as well as good behaviour under compression stress. Good wetting of the base material with lower working temperature compared to copper. Flat seams due to Si content and little pore formation.

Welding of galvanised auto body steel sheets (MIG brazing), un-alloyed and low-alloyed steels, cast iron as well as copper and copper alloys. With MIG burner: Weld sharp, not dragging.

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

Melting range: 1030 - 1050 °C  
Tensile strength: 285 N/mm<sup>2</sup>  
Yield strength: 140 N/mm<sup>2</sup>  
Elongation (l=5d): up to 40 %  
Impact energy: 75 J  
Hardness (Brinell): 62 HB  
Thermal conductivity: 40 W/m • K  
Specific gravity: 8.7 g/cm<sup>3</sup>  
Linear expansion: 18.1 • 10<sup>-6</sup>/K

**Welding process:** MIG

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

**Current mode:** DC (+pole)

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

**Spool type:** B300  
S300

**Welding position:** according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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