FONTARGEN A 207 W

Copper-silicon-manganese welding rod

ISO 24373:	S Cu 6511 (CuSi2Mn1)
Material-no.:	2.1522

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

Si	Sn	Mn	Cu
1.8	0.2	1	Remainder

Characteristics / Applications:

Easy to weld. High temperature- and corrosion resistance as well as good behaviour under compression stress. Good wetting of the base material with low working temperature compared to copper. Flat seams due to silicon content. Little pore formation. Welding deposit has good modelling properties. Welding of galvanised autobody steel sheets, other steels as well as copper, copper alloys and cast iron.

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

Melting range:	1030 - 1050 °C
Tensile strength:	285 N/mm²
Yield strength (0.2 %):	140 N/mm²
Elongation (l=5d):	45 %
Hardness (Brinell):	62 HB
Electrical conductivity:	4.7 - 5.3 Sm/mm^2
Heat conductivity:	40 W/m • K
Specific gravity:	8.7 g/cm³
Coefficient of expansion:	18.1 •10^{-6}/K
Welding process:	TIG
Shielding gas (DIN EN 439):	I 1 (Argon)
Current mode:	DC (-pole)
Availability:	Diameter (mm): 1.6/2.0 Length (mm): 1000
Welding position:	according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
☒	☒	☒	☐	☒	☒	☐

13/11/JL/1