

## Cu-base solid wire

### Classification

AWS A5.7-84R : ERCu  
EN 14640 : S Cu 1898 (CuSn1)

### General description

Solid wire for GMA-welding of copper

### Shielding gases (acc. EN 439)

GMAW	I1	Inert gas Ar (100%)
	I3	Inert gas Ar+ >0-95% He

### Chemical composition (w%). typical. wire

Cu	Mn	Si	Sn	Ni
bal.	0.2	0.3	0.8	0.1

### Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Hardness HB
Typical values	GMAW	I1	AW	100	220	60	35

### Materials to be welded

Material type	Code	Type	W.Nr.
Copper	DIN 1787	OF-Cu	2.0040
		SE-Cu	2.0070
		SW-Cu	2.0076
		SF-Cu	2.0090
		Wrought low alloyed copper alloys	DIN 17666
		CuSP	2.1498
		CuTeP	2.1546

### Packaging and available sizes

Process	Unit	Diameter (mm)	1.0	1.2
GMAW	12 kg spool B300		X	X

Other sizes and packaging on request

LNM CuSn: rev. EN 20