

Cu-base solid wire

Classification

EN 14640 : S Cu 5410 (CuSn12P)

General description

Solid wire for GMA-welding of copper-tin and copper-zinc alloy

Shielding gases (acc. EN 439)

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

Chemical composition (w%). typical. wire

Cu	Sn	P
bal.	12	0.2

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)
Typical values	GMAW	I1	AW	100	250	30

Materials to be welded

Copper-tin alloys, e.g. bronze with 10-12% tin
Copper-zinc alloys e.g. brass

Packaging and available sizes

Process	Unit	Diameter (mm)	0.8
GMAW	12 kg spool B300		X

Other sizes and packaging on request

LNM CuSn12: rev. EN 20