FONTARGEN A 200 SM

Copper wire electrode for MIG-welding

ISO 24373:	S Cu 1898 (CuSn1)
AWS A 5.7:	ERCu
Material-no.:	2.1006

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

Sn	Si	Mn	Cu
0.8	0.3	0.3	Remainder

Characteristics / Applications:

Joint and build-up welding on oxygen-free copper and copper alloys of material numbers: 2.0040, 2.0060, 2.0070, 2.0080, 2.0090, 2.0100, 2.0120, 2.0150, 2.0170, 2.1202, 2.1322, 2.1325, 2.1491. Suitable for out-of position welding. Clean base materials in the welding spheres and preheat if over 3 mm (per mm of plate thickness approx. 100 °C, but not more than 600 °C). Suitable for welding of galvanised steel (MIG-brazing).

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

Melting range:	1020 - 1050 °C
Tensile strength:	200 - 240 N/mm²
Elongation (l=5d):	30 %
Thermal elongation:	18.1 • 10^{-6}/K
Impact energy (ISO-V):	75 J
Hardness (Brinell):	50 - 60 HB
Electrical conductivity:	15 - 20 Sm/mm²
Heat conductivity:	120 - 145 W/m • K
Specific gravity:	8.9 g/cm³
Welding process:	MIG
Shielding gas (DIN EN 439):	I 1 (Argon), I 3 (Ar-He mixture)
Current mode:	DC (+pole)
Availability:	Diameter (mm): 0.8/1.0/1.2/1.6
Spool type:	B300, S300
Welding position:	according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
☒	☒	☒	☐	☒	☒	☐

13/10/JL/1

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