FONTARGEN A 202 W

Copper-silicon welding rod



ISO 24373:	S Cu 6560 (CuSi3Mn1)
AWS A 5.7:	ERCuSi-A
Material-no.:	2.1461

Composition, typical analysis (% w/w):

Si	Sn	Zn	Mn	Fe	Cu
2.9	0.1	0.1	1	0.1	Remainder

Characteristics / Applications:

High temperature- and corrosion resistance as well as good behaviour to compression stress. Thanks to high silicon content liquid welding deposit that results in flat seams.

Joint and build-up welding on copper alloys of material numbers 2.0853, 2.0855, 2.0857, 2.1243, 2.1245, 2.1247, 2.1265, 2.1266, 2.1267, 2.1270, 2.1285, 2.1322, 2.1323, 2.1363, 2.1366, 2.1522, 2.1525, 2.1545, 2.1546, brass as well as build-up welding on unalloyed or low-alloyed steels and cast iron. To avoid hot cracks keep welding pool small and feed fast. Preheat thick workpieces to 350 - 600 °C.

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

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Melting range:	910 - 1025 °C
Tensile strength:	350 N/mm²
Yield strength (0.2 %):	120 N/mm ²
Elongation (I=5d):	40 %
Thermal elongation:	18 • 10⁻⁶/K
Hardness (Brinell):	85 - 100 HB
Electrical conductivity:	3 - 4 Sm/mm ²
Heat conductivity:	35 W/m • K
Specific gravity:	8.5 g/cm ³
Welding process:	TIG
Shielding gas (DIN EN 439):	I 1 (Argon)
Current mode:	DC (-pole)
Availability:	Diameter (mm): 1.6/2.0/2.4/3.2 Length (mm): 1000
Walding a selfier.	DIN EN 007

Welding position: according to DIN EN 287 PA PB PC PD PE PF Image: Image of the second secon

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