

Standards

TS EN ISO 17672: Cu 922
EN ISO 17672 : Cu 922
AWS A5.7 : ER CuSn-A

Chemical Composition of Weld Metal % (Typical)

Cu	Sn	P
Rest	6.0	0.20

Mechanical Properties


Melting Range (°C)	Density (kg/dm ³)	Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation ((L ₀ =5d ₀) (%))	Hardness (HB)
910-1040	8.7	300	150	20	80

Features and Applications

- Highly wear resistant, good anti-friction properties suitable for joining copper-zinc alloys and coating of cast irons and steel materials and dissimilar materials like as steel and bronze
- Applications include bearing faces, art bronze, axle bearing
- Shielding Gas for TIG Welding: Ar
- Normal flame must be chosen
- 100 - 250°C pre-heat temperature must be done thicker than 10 mm materials

Welding Method

Gas Welding - TIG Welding

Current Type	MIG Wire	Electrode	Welding Positions
TIG D.C.(-)	GeKa R4 L	GeKaTec Bronze	

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100388	2.0 x 1000	5/64 x 39"	5

Approvals: SEPRO