

**Standards :**

**Chemical Composition of Welding Wire  
% (Typical) :**

TS EN ISO 24373 : -S Cu1898 (CuSn1)
EN ISO 24373 : -S Cu1898 (CuSn1)
AWS A 5.7 : ER Cu

Si	Mn	Sn	Cu
0.3	0.3	0.8	rest

**Mechanical Properties :**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (L <sub>c</sub> =5d <sub>s</sub> )(%)	Hardness (HB)
115	200	35	60

**Typical Base Material Grades :**

\* OF-Cu, SE-Cu, SW-Cu, SF-Cu, Cu Fe 2P, CuSP, CuTeP, E-Cu C, F-Cu, D-Cu, SD Cu, SB-Cu, SA-Cu.

**Features and Applications :**

- \* It is Cu-Sn alloy welding wire.
- \* It is used in welding of pure copper and copper based low alloy, tank and boilers, graphite electrode holders, slag baths, oxygen tubes, electrical equipment.
- \* Shielding Gas: Ar, He, Ar+He

**Welding Positions :**



**Current Type :**

MIG D.C.(+)

**Operating Data :**

Diameter x Length (mm)	Diameter x Length (inch)	Package Weight (Kg)
1.0	0.040"	15
1.2	0.047"	15
1.6	0.062"	15

**Approvals :**

GOST-R, SEPRO