

BERCOWELD[®] K5 (CSSM)

Cu-alloy wire electrode for MIG and TIG welding

Standard designation ISO 24373 : Cu 1898 CuSn1

Composition (weight %)

Cu	: balance
Sn	: 0,75-0,90
Mn	: 0,15-0,30
P	: 0,005-0,020
Si	: 0,15-0,25
Others	: max. 0,5

Physical standard data

Density	kg/dm ³	: 8,9
Melting range	°C	: 1020-1050
Thermal conductivity	W/m·K	: 120-145
Coefficient of linear mean expansion (20°C-300°C)	1 / K	: 18,1·10 ⁻⁶
Electric conductivity	m/Ω·mm ²	: 15-20
Resistivity	Ω·mm ² /m	: 0,05-0,0667

Mechanical properties of the weld joint, standard data

Heat treatment		non treated
Tensile strenght	N/mm ²	: 220
Elongation	%	: 30
Brinell hardness	HB 2,5/62,5	: 60
Notched bar impact test	A _v (J)	: 75

Range of application

Suitable for heavy-duty welded joints on oxygen-free copper and Cu materials. Very easy to handle and pore-free welds. Pre-heating to 300°C is recommended for WIG-welding large work pieces.

Recommendation

Applicable inert gas Argon 4.8/ 5.0/ 5.3/ 5.6/ 6.0

Make up

Diameter: 0,80 - 1,00 - 1,20 - 1,60 - and 2,40 mm.
Spools: D 300, H 370 and wire basket spools (acc. to DIN 8559).
Rods: 2,00 - 6,00 mm Ø x 1000 mm.
Further make ups on request.

www.bercoweld.com