



INTERMETAL

Data sheet COROBRONZE BI66

Cu alloy wire electrode for MIG and TIG welding

Standard designation

EN 14640	: CuSn6P	Cu5180
DIN 1733	: SG-CuSn6	
Material no.	: 2.1022	
BS 2901P.3	: C11	
AWS A5.7-84	: ERCuSn-A	

Composition (weight %)

Cu	: balance
Sn	: 6,00-6,60
P	: 0,20-0,25
Others	: max. 0,5

Physical standard data

Density	kg/dm ³	: 8,7
Melting range	°C	: 910-1040
Thermal conductivity	W/m K	: 75
Coefficient of linear mean expansion (20°C-300°C)	1/K	: 18,1 • 10 ⁻⁶
Electric conductivity	m/Ω mm ²	: 6-7
Resistivity	Ω mm ² /m	: 0,143-0,167

Mechanical properties of the weld joint, Standard data

Thermal treatment		not treated
Tensile strength	N/mm ²	: 260
Elongation	%	: 20
Brinell hardness	HB 2,5/62,5	: 80
Notched bar impact test	A _v (J)	:

Range of application

Tin bronze alloy of 6 % tin min., suitable for every welding. Surfacing and joining of CuSn alloys, CuSnZnPb cast alloys and cast iron. Appropriate to oven soldering, good deoxidation effect.

Recommandation

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

Make up

Sizes: Ø - 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
Other sizes and lengths on request.