

# WISDOM Thermal Spray Consumables

## Copper base alloy



CuSn1

DATA SHEET

November 2015

### Introduction

CuSn1 contains 98% copper and small amounts of phosphorus and silicon. Is easy flowing and produces weld deposits that are porosity free, electrically conductive and color will match that of copper.

### SURFACE PREPARATION

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. Note: It is best not to handle surfaces after cleaning.

Recommended method of preparation is, to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe.

### Application

- Good mechanical properties and crack resistance
- Gas welding and argon arc welding of red copper.

### Composition(standard value)%

Standard	Class	Alloy	Cu	Mn	P	Si	Sn	other
BS EN14640	Cu 1898	CuSn1	Rest	0.3	0.01	0.3	0.8	<0.5

### Typical Physical Properties

Solids-Temperature	Liquids-Temperature
1020°C	1050°C

### Standard Sizes & Packing

Diameter	Dimension Tolerance	Packing	Wire Weight
1/16"(1.6mm)	+0/-0.05	D 300 Spool	15kgs(33 lbs)/spool
2.0mm	+0/-0.05	D 300 Spool	15kgs(33 lbs)/spool
1/8"(3.17mm)	+0/-0.05	Coil Form	20-400kgs/coil

Other sizes can be produced by customers' requirement.

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