

bercoweld® B10 is used for buildup welding on cast iron. Especially suitable for welding deep drawing sheet steel (like body panels). With this welding filler, wide seam gaps can be bridged due to its good flow properties. Very suitable for oven soldering.

Pulsed power welding is recommended. Preheating the base material is generally not required.

Standardization and composition

ISO 24373	CuSn10MnSi Cu5211
Cu	balance
Sn	9.00 - 10.00
Mn	0.20 - 0.35
Others	max. 0.5

Physical properties

Density (kg/dm³)	8.7
Melting range (°C)	887 - 1020
Thermal conductivity (W / m x K)	47
Coefficient of linear mean expansion (10⁻⁶/K)	18
Electric conductivity (m / Ω x mm²)	5 - 6
Resistivity (Ω x mm² / m)	0.1667 - 0.2000

Mechanical properties of the weld joint (standard data)

Heat treatment	non treated
Tensile strength (MPa)	290
Elongation (%)	14
Brinell hardness (HB 2.5/62.5)	115
Notched bar impact test (Av (J))	24

Delivery options

Make-up	Weight/Length	Dimension
Drum / bedradox	175 - 200 kg	0.80 - 1.60 mm
SD300 / BS300 / K300	12 - 15 kg	0.80 - 2.40 mm
H500 / H560 / H760	150 - 250 kg	0.80 - 2.40 mm
Coils	25 - 100 kg	1.60 - 6.00 mm
Rods	250 - 3000 mm	1.60 - 6.00 mm