

bercoweld® BS60 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 | CuZ (CuSn6MnSi) |
| Cu | balance |
| Sn | 5.50 - 6.00 |
| Mn | 0.20 - 0.35 |
| Si | 0.20 - 0.30 |
| Others | max 0.5 |

Standardization and composition

| | |
|---|---------------|
| Density (kg/dm³) | 8,8 |
| Melting range (°C) | 900 - 1040 |
| Thermal conductivity (W / m x K) | 62 |
| Coefficient of linear mean expansion (10⁻⁶/K) | 18,4 |
| Electrical conductivity (m / Ω x mm²) | 7,3 - 7,9 |
| Resistivity (Ω x mm² / m) | 0,125 - 0,135 |

Mechanical properties of the weld joint (standard data)

| | |
|---|-------------|
| Heat treatment | non treated |
| Tensile strength (MPa) | 359 |
| Elongation (%) | 44 |
| Brinell hardness (HB 2.5/62.5) | 101 |
| Notched bar impact test (Av (J)) | 68 |

Delivery options

| Make-up | Weight/Length |
|-----------------------------|----------------------|
| Drum / bedrabox | 175 - 200 kg |
| SD300 / BS300 / K300 | 12 - 15 kg |
| H500 / H560 / H760 | 150 - 250 kg |
| Coils | 25 - 100 kg |
| Rods | 250 - 3000 mm |