

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	Cu5285 (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