

ISOFIL AWD 23

(REF: K05938/B6)

ISOFIL AWD 23 is used for build-up and join welding on CuSn alloys, CuSnZnPb cast alloys and cast iron. Preferred for oven soldering, good deoxidizing effect.

Standardization and composition

ISO 24373	CuSn6P Cu5180
Cu	balance
Sn	6.00 - 6.60
P	0.20 - 0.25
Others	max. 0.5

Physical properties

Density (kg/dm³)	8.7
Melting range (°C)	910 - 1040
Thermal conductivity (W / m x K)	75
Coefficient of linear mean expansion (10⁻⁶/K)	18.1
Electric conductivity (m / Ω x mm²)	6 - 7
Resistivity (Ω x mm² /m)	0.143 - 0.167

Mechanical properties of the weld joint (standard data)

Heat treatment	non treated
Tensile strength (MPa)	260
Elongation (%)	20
Brinell hardness (HB 2.5/62.5)	80
Notched bar impact test (Av (J))	32

Delivery options

Make-up	Weight/Length	Dimension
Drum / bedrabox	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



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