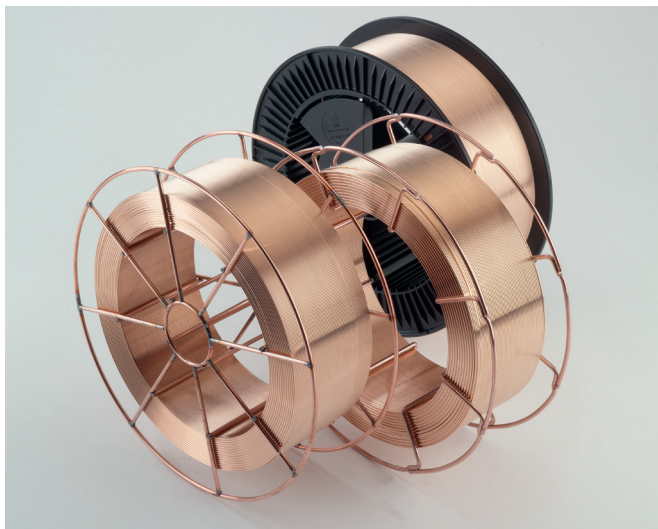


bercoweld®

BERCOWELD BS60 for best quality joint welds

This high-tech filler metal is especially suitable for the joining of ferritic and zinc coated steel especially for applications in the thin sheets range for the automotive industry.



In addition to material joining in the automotive industry, BERCOWELD BS60 from Berkenhoff is utilized for special applications like valve-, control- or pump housings. Furthermore this filler metal is particularly suitable for overlay welding on steel and copper.

All joining variants – like fillet-, lap-, flange joints as well as class A carbody applications – can be realized without any problems. Class A applications are state of the art in carbody manufacturing. We recommend that pulse arc welding for multi-layer welding on steels be utilized for these applications. For the processing of this alloy gases like pure argon or argon with an active component (e.g. 1% O₂ or 2% CO₂) are used.

MIG-brazing with the tin bronzes BERCOWELD BS60 offers significant advantages over MIG-brazing with usual filler metals, for example:

- less finishing operation
- no corrosion of the welds (low temperature melting)
- less stress in the weld metal
- excellent gap bridging
- less heat penetration
- excellent flow behavior
- antibacterial

The alloy is certified by the TÜV-Rheinland and has the CE-conformity sign.



Technical data BERCOWELD BS60 (standard values)

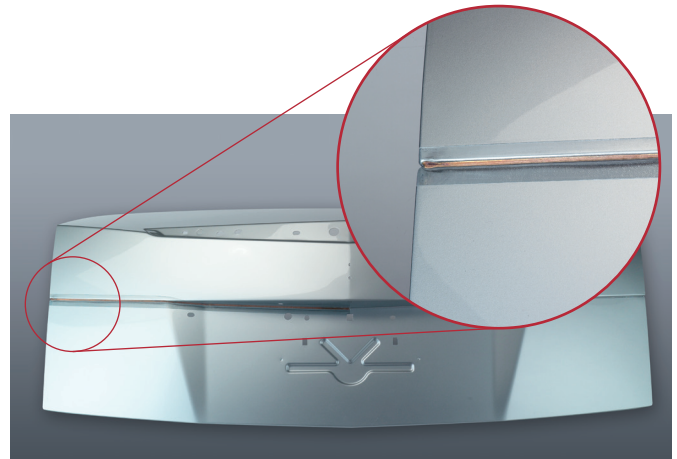
Alloy composition in %

Cu	Balance
Sn	5,50 – 6,00
Mn	0,20 – 0,35
Si	0,20 – 0,30
Others	max. 0,5

Density (kg/dm ³)	8,8
Melting range °C	900 – 1040
Tensile strength (N/mm ²)	360
Elongation %	44
Brinell hardness HB 2,5/62,5	101
Notch-impact values Av (J)	68

Make up Available as MIG/MAG wire in spools, bedrabox, drums and coils as well as WIG-rods.

Dimension All common dimensions available, special diameters on request.



Berkenhoff GmbH
Berkenhoffstrasse 14
35452 Heuchelheim
Phone +49 641 601-0
Fax +49 641 601-212
E-mail: info@bedra.com

www.bercoweld.com

