

Alloy Designation	
EN	CuZn15
DIN CEN/TS 13388	CW502L
JIS	
BS	
UNS	C23000

Chemical Composition		
Weight percentage		
Cu	85	%
Zn	Rest	%

This alloy is in accordance with RoHS 2002/96/CE for electric & electronic equipments and 2002/53/CE for automotive industry

Brass Rolled Products



KME offers a wide range of brass rolled products in the form of strips, sheets and discs in order to meet our customer's needs for industrial manufacturing or for the production of gift articles and decorative objects.

Characteristics

CuZn15 has excellent cold forming, good hot forming properties and is well suited for e.g. coinage, beating, embossing. This alloy has a higher strength than pure copper. CuZn15 has good welding and brazing properties as well as a good corrosion resistance and is not fragile to stress corrosion and dezincification. It is principally used in jewellery, metal goods, watch industry and in electronic industry for installation parts. We produce qualities with grain sizes below 5 µm if needed.

Main Applications

Architecture: Trim, Etching Parts, Weather Strip
Builders Hardware: Kick Plates
Consumer: Rouge Boxes, Dial, Coinage, Token, Lipstick Containers, Fire Extinguisher Cases, Costume Jewelry, Compacts, Plaques, Medallions, Nameplates, Badges, Zipper
Electrical: Rotor Bars, AC Motors, Sockets, Screw Shells, Conduit
Fasteners: Eyelets, Fasteners
Industrial: Condenser Tubes, Pickling crates, Radiator Cores, Heat Exchangers, Flexible Metal Hose, Fire Extinguishers, Pump cylinder Liners, Tags, Tubing for Heat Exchangers, Tubing for Instrumentation, Heat Exchanger Shells
Other: Fire Hose Couplings
Plumbing: Pump Line, Pipe, Service Lines, J-Bends, Traps, Pipe Service Lines, Pipe Nipples, Fittings
Typical Application: Jewellery and Metal Goods, Components for the Electrical Industry, Cladding Panels

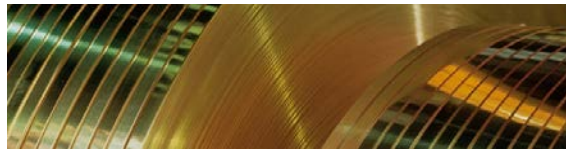
Preferred Applications

Jewellery and Metall Goods	Deep Drawn Parts	Components for the Electrical Industry	Cladding Parts	Connectors
xx		xx	xx	

x = well suited xx = particularly well suited

Physical Properties
 Typical values in annealed temper at 20 °C

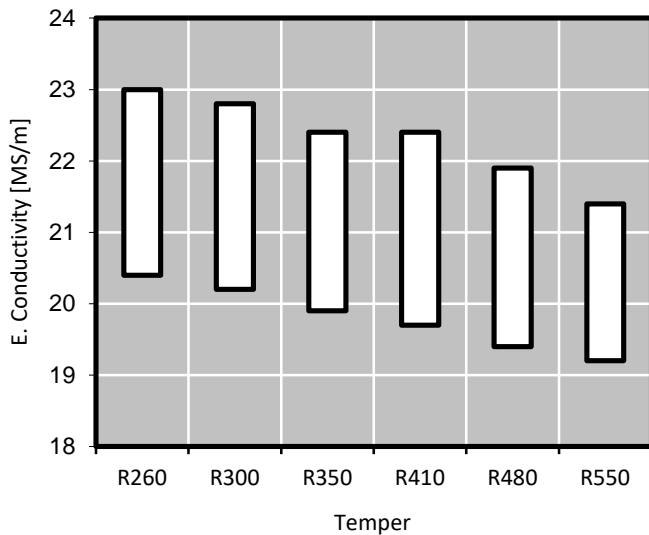
Density		8.75	g/cm ³
Thermal expansion coefficient	20 .. 100 °C	9.0	10 ⁻⁶ /K
	20 .. 300 °C	18.5	10 ⁻⁶ /K
Specific heat capacity		0.377	J/(g·K)
Thermal conductivity		159	W/(m·K)
Electrical conductivity (1 MS/m = 1 m/(Ω mm ²))		≥ 20	MS/m
Electrical conductivity (IACS)		34	%
Thermal coefficient of electrical resistance (0 .. 100 °C)		2.6	10 ⁻³ /K
Modulus of elasticity (1 GPa = 1 kN/mm ²) cold formed		99 .. 115	GPa
	annealed	122	GPa



Mechanical Properties (EN 1652)					
Temper		Tensile Strength Rm	Yield Strength Rp0.2*	Elongation Minimum A50mm	Hardness HV *
		MPa	MPa	%	HV
R260	annealed	260 .. 310	≤170	36	55 .. 85
R300	annealed	300 .. 370	≥170	16	85 .. 120
R350		350 .. 420	≥ 250	8	100 .. 150
R410		410 .. 490	≥ 360	3	125 .. 155
R480		480 .. 560	≥ 420	1	150 .. 180
R550		≥ 550	≥ 480	-	> 170

* only for information

Electrical Conductivity



Electrical conductivity is strongly influenced by chemical composition. A high level of cold deformation and small grain size decrease the electrical conductivity moderately. Minimum conductivity level can be specified.

Fabrication Properties*	
Cold Forming Properties Max. 90% between annealings	Excellent
Hot Forming Properties at 780 .. 900°C	Good
Machinability (Rating 30)	Less suitable
Electroplating Properties	Excellent
Hot Tinning Properties	Excellent
Soft Soldering, Brazing	Excellent
Resistance Welding	Good
Gas Shielded Arc Welding	Good
Laser Welding	Fair
Soft Annealing	450 .. 680°C
Stress Relieving Annealing	200 .. 300°C

* For more details call our technical service

Corrosion Resistance*

Resistant to:

CuZn15 has in general a good resistance to natural-, sea- and industrial atmosphere, water, water vapour, different saline solutions, many organic liquids, neutral- and alkaline bonds.

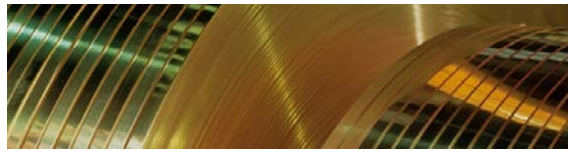
CuSn15 has a low sensitivity to stress corrosion cracking. To avoid stress corrosion as much as possible, the alloy should be used in a stress relieved temper.

CuSn15 is not sensitive to dezincification, that could occur in water with high chlorine content and low carbonat-hardness.

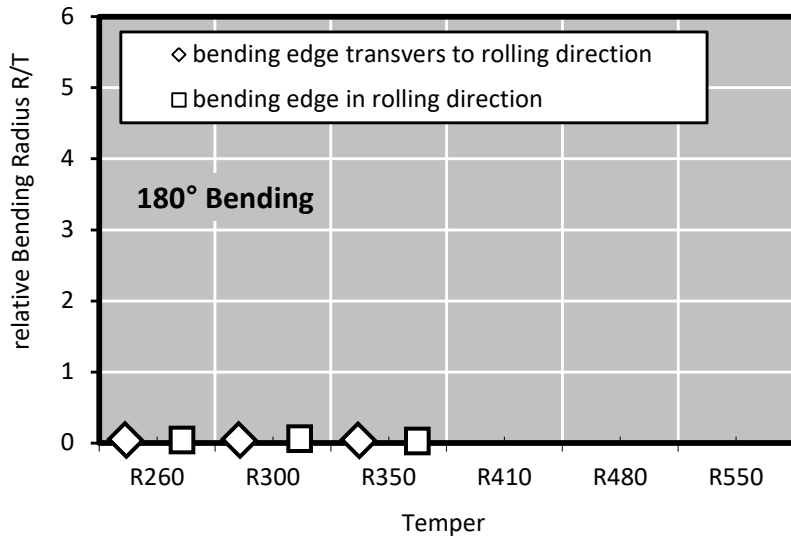
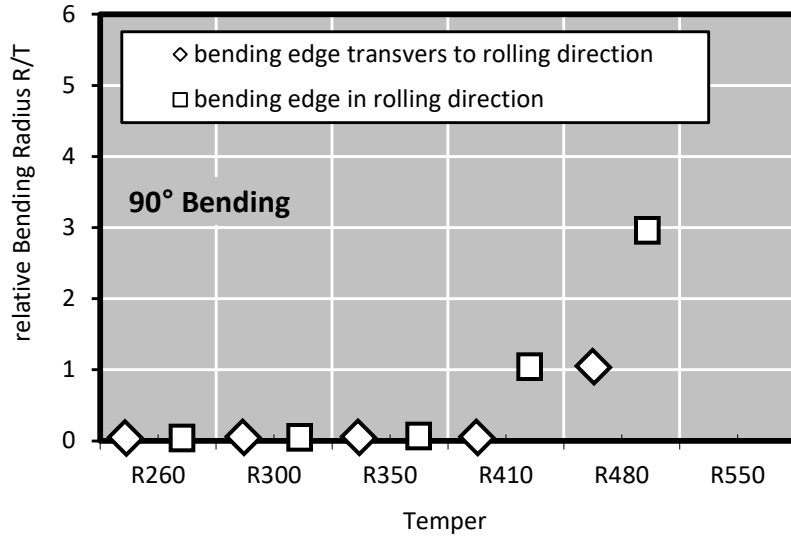
Not resistant to:

Oxidizing acids, hydrous sulphur components, hydrous ammonia in the non-stress-relieved condition.

* For more details call our technical service



Bending Properties Thickness: ≤ 0.5 mm

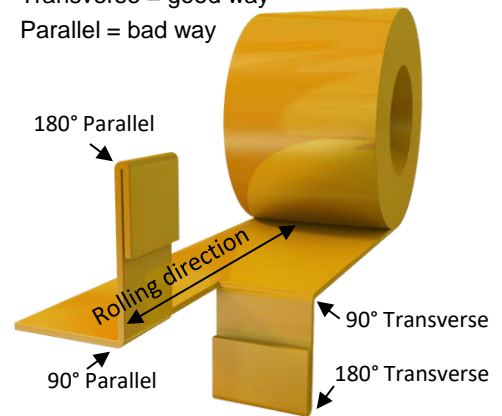


Bending test according to EN ISO 7438 is done with 10 mm wide samples. Smaller samples in general – as well as lower thickness – allow a lower bending radius without cracks. If needed we supply bending optimized temper classes that far exceed standard quality.

Please take care when comparing with ASTM E 290 results, there the bend definition direction is contradictory.

Bending Definition

Transverse = good way
Parallel = bad way



Minimum Bending Radius Calculation

To find out the minimum possible bending radius take the R/T value from the list.

Example: R/T = 0.5 and thickness 0.3 mm
Minimum radius = (R/T) x thickness
= 0.5 x 0.3 mm = 0.15 mm

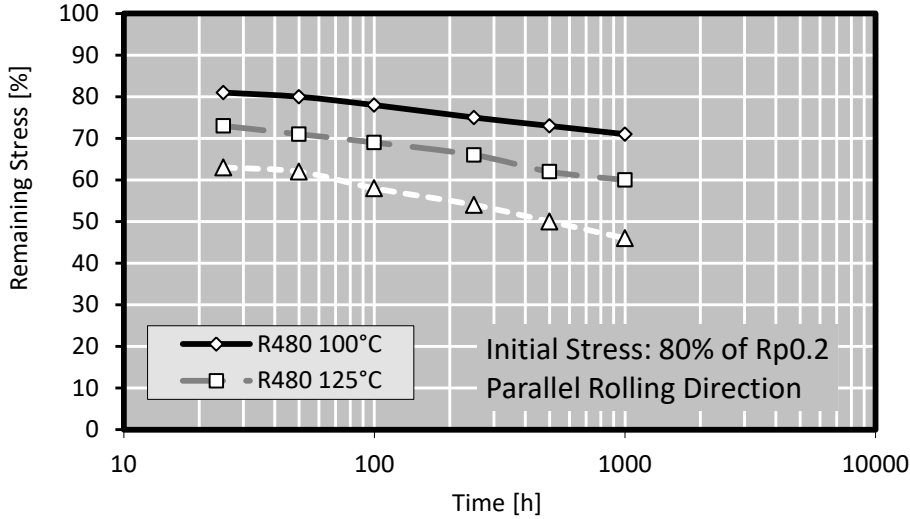
Bending Properties*

Temper	Bending 90°		Bending 180°	
	Trans-vers	Parallel	Trans-vers	Parallel
	R/T	R/T	R/T	R/T
R260	0	0	0	0
R300	0	0	0	0
R350	0	0	0	0
R410	0	1	-	-
R480	1	3	-	-
R550	-	-	-	-

* Measured at sample width 10 mm according to EN 1654
Possible bending radius = (R/T) x thickness



Relaxation Properties

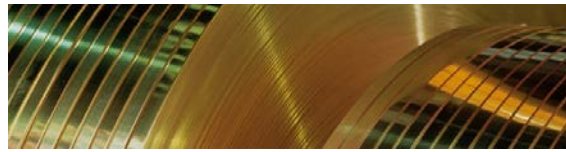


Stress relaxation is tested with cantilever bending test equipment. This method is taking short time relaxation into account, so that the values achieved are very realistic, while other test methods like tube test pretend better properties from the achieved values. Relaxation values give an indication about stress relieve of strip under tension for a certain time and temperature. As it is measured on plain strip, the behaviour of deformed parts may differ, nevertheless the ratio between the different tempers remains the same.

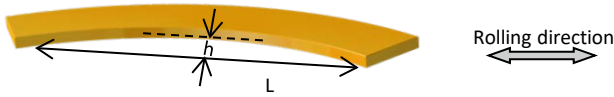
Typical test sample thickness is 0.3 – 0.6 mm.

Bend Fatigue (at room temperature)

The fatigue strength gives an indication about the resistance to variations in applied tension. It is measured under symmetrical alternating load. The maximum bending load for 10^7 load cycles without crack is measured. Dependent on the temper class it is approximately 1/3 of the tensile strength R_m .



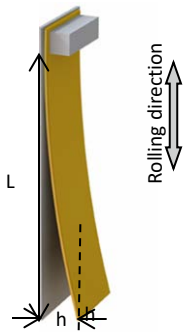
Camber



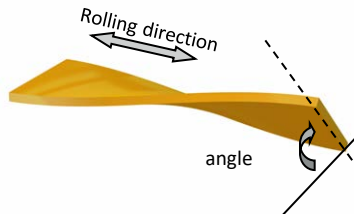
Evenness



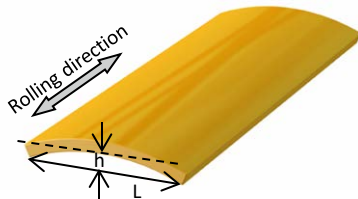
Coil set



Twist



Transverse Flatness



Evenness Tolerance

Thickness Range [mm]	Width Range [mm]		
	7 .. 20	21 .. 50	51 .. 100
0.10 .. 0.50	+0.10	+0.20	+0.30
0.50 .. 1.00	+0.15	+0.25	+0.35

Width Tolerance Standard / Precision

Thickness Range [mm]	Width Range [mm]				
	10 .. 50	51 .. 100	101 .. 200	201 .. 350	351 .. 700
0.10 .. 1.00	+0.2 / +0.1	+0.3 / +0.2	+0.4 / +0.3	+0.6 / +0.4	+1.0 / +0.5
0.20 .. 1.00	+0.2 / +0.1	+0.3 / +0.2	+0.4 / +0.3	+0.6 / +0.4	+1.0 / +0.5
1.01 .. 2.00	+0.3 / +0.2	+0.4 / +0.2	+0.5 / +0.4	+1.0 / +0.6	+1.5 / +0.7
2.01 .. 3.00	+0.5 / +0.3	+0.6 / +0.3	+0.7 / +0.5	+1.2 / +0.7	+2.0 / +0.9
3.01 .. 6.00	+2.0 / -	+2.3 / -	+2.5 / -	+3.0 / -	+4.0 / -

Customized Tolerances

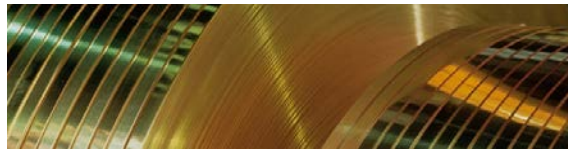
Our products are produced in accordance with relevant norms EN 1652 / EN 1654. Customer specific tolerances for Thickness, Width, Camber, Transverse Flatness, Evenness, Twist and Coil set can be defined. We will be happy to meet your demands. EN 1652 defines only camber.

Thickness Tolerance

Thickness Range [mm]	EN 1652 ≤350 mm [mm]	KME Standard [mm]	KME Precision [mm]
0.10 .. 0.20	± 0.018	± 0.005	± 0.004
0.21 .. 0.30	± 0.022	± 0.007	± 0.005
0.31 .. 0.40	± 0.025	± 0.015	± 0.006
0.41 .. 0.50	± 0.030	± 0.015	± 0.008
0.51 .. 0.60	± 0.040	± 0.017	± 0.010
0.61 .. 0.70	± 0.040	± 0.020	± 0.010
0.71 .. 0.85	± 0.040	± 0.022	± 0.012
0.86 .. 1.30	± 0.050	± 0.025	± 0.015
1.31 .. 2.00	± 0.060	± 0.030	± 0.020
2.01 .. 3.00	± 0.070	± 0.045	± 0.025
3.00 .. 4.00	± 0.100	± 0.050	± 0.025
4.00 .. 6.00	± 0.120	± 0.060	± 0.030

Roughness

Ra [μm]	Thickness [mm]
0.13 .. 0.18	0.1 .. 2.0
0.20 .. 0.30	0.1 .. 2.0
0.35 .. 0.46	0.1 .. 2.0
On request	> 2.0



Formats	Dimension*			
	Coil	Strip thickness (other thicknesses on request)	≥ 0.05 .. 6.00	mm
		Strip width	≥ 3 .. 1,000	mm
		Outside diameter	≤ 1,400	mm
		Weight (Standard)	≤ 8,400	kg
		Weight (Deep-Drawing Quality)	≤ 8,000	kg
		Weight per mm	≤ 12.0	kg
	Traverse wound strip	Thickness	≥ 0.2 .. ≤ 1.50	mm
		Width	≥ 8 .. ≤ 60.0	mm
		Weight	300 .. 1,500	kg
		Drums: wood, plastic, metal, flangeless		
	TECSTRIP® _multicoil	Thickness	0.18 .. 0.80	mm
		Width	15 .. 50	mm
		Inner diameter 300 mm for thickness	0.15 .. 0.80	mm
		Inner diameter 400 mm for thickness	0.41 .. 0.80	mm
		Maximum weight	5,000	kg
		Outer diameter maximum	1,600	mm
	Sheet ≤ 6.35 mm	Thickness	0.3 .. 6.35	mm
		Width	50 .. 1,000	mm
		Length	200 .. 6,500	mm
		Weight	2,800 .. 8,000	kg
		Sheets in standard dimensions e.g. 1,000 x 2,000 mm on stock		
	Sheet > 6.35 mm	Thickness	6.35 .. 9.50	mm
		Width	50 .. 1,000	mm
		Length	200 .. 7,500	mm
		Weight	≤ 10,000	kg
		Sheets in standard dimensions e.g. 1,000 x 2,000 mm		
	Plate	Thickness	9.5 .. 150	mm
		Width	≤ 1,000	mm
		Length	≤ 15,000	mm
		Weight	≤ 8,000	kg
	Disc	Thickness	0.3 .. 150	mm
		Diameter	20 .. 1,000	mm
		Weight	≤ 10,000	kg

* Some combinations might not be possible



Surface coatings & Special Treatments *		Dimension	
	Hot-Dip tinned and STOL®28M Tin-Silver STOL®13 Thermic Sn	Width	≤ 330 mm
		Thickness	≤ 1.5 mm
		Tin Layer Thickness	0.4 .. 20 μm
Different thickness per side possible			
	Electroplating	Width	≤ 400 mm
		Thickness	≤ 2.5 mm
	Tin, Silver, Gold, Cu-Flash, Ni-Flash, Selective plating	Other coatings on request	
	Profiled strips STOL®Multigauge	Width	15 .. 90 mm
		Thickness	0.23 .. 1 mm
	Other width on request		
	Bright and polished appearance	Width	≤ 1,000 mm
		Thickness	≤ 1.5 mm
	GS1 Surface Quality	Skin passed material	
	Surface with extra low residual carbon content possible.		
	Protection with oil or adhesive foil on request		

* Further details you find at www.kme.com

Standards for copper and copper alloys

EN 1652	Plate, sheet, strip and circles for general purposes
EN 1654	Strip for springs and connectors
EN 1758	Strip for lead frames
EN 13148	Hot-dip tinned strip
EN 13599	Copper plate, sheet and strip for electrical purposes
EN 14436	Electrolytically tinned strip