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DATA SHEET:
EURO-HS CW617N

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FREE MACHINING

HUG

High workability alloy and reduced lead content.

The demand for alloys with reduced lead content, but with high machinability due to chip removal, has allowed the development of a high performance alloy. Inserted in the "Positive List" of the 4MS it is usable up to 10% of the surface of the domestic system of distribution of drinking water.

NAME OF ALLOY

UNI EN: CW617N - CuZn40Pb2 **ASTM:** C37700 **DIN:** 2.0402 **BS:** CZ122 **GOST:** LS59-2

CHEMICAL COMPOSITION UNI EN 12164:2024

Cu	Pb*	Sn	Fe	Ni*	Si*	Zn	Other elements
min. 57.0 max. 59.0 %	1.6 2.2 %	≤0.3 %	≤0.3 %	≤0.1 %	≤0.03 %	difference	≤0.2 %

*Limitation according 4MS. Elements not listed must be ≤0.02 %.
Group of restriction of the surface in contact with drinking water: B,D.

HEAT TREATMENTS

STRESS RELIEVING

Enables the redistribution of tensions induced by mechanical processing of cold plastic deformation, reducing the risk of stress corrosion cracking.
The treatment consists of heating the items to 200°C - 250°C for 2 hours and cooling within the furnace. The validation of the stress relieving treatment can be performed with the ISO 6957 test.

ANNEALING

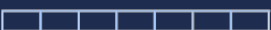
Re-crystallizes the alloy, reducing its hardness and increasing its ductility.
The temperature of the treatment varies from 450°C to 550°C for an amount of time relative to the required results. The high temperature can induce changes in the surface appearance and in the tolerance of the finished part.





MECHANICAL PROPERTIES UNI EN 12164:2024

Condition of material	Diameter in mm		Hardness HBW		Rm	Rp _{0.2} N/mm ²		Elongation %
	from	to (included)	min.	max.	min.	min.	max.	min.
M	All		As a product					
R360	6	80	-	-	360	-	320	20
H090	6	80	90	125	-	-	-	-
R430	2	40	-	-	430	220	-	10
H110	2	40	110	160	-	-	-	-
R500	2	14	-	-	500	350	-	5
H135	2	14	135	-	-	-	-	-

The hardness value is determined in the mid-range.
The standard condition produced by Almag is R500 from Ø > 6 to Ø ≤ 11 and R430 from Ø > 11 for Rm, or H110 for hardness.
Any other conditions must be requested when ordering - subject to feasibility request.

TECHNOLOGICAL PROPERTIES

low  excellent

Structure	$\alpha+\beta$	Machinability	
Density	8.4 kg/cm ²	Weldability	
Electrical conductivity	27% IACS	Hot forming	
Coeff. of thermal expansion	20.7 10 ⁻⁶ /K	Cold forming	
Thermal conductivity*	120 W/(m K)	Corrosion resistance**	Not resistant
Specific heat	380 J/(kg K)		
Elasticity module	105 kN/mm ²		
Melting point	880-895 °C		

*at room temperature

**use care to ascertain compatibility with chemical substances

DIMENSIONS, TOLERANCES, AND STRAIGHTNESS UNI EN 12164:2024

ROUND section bar

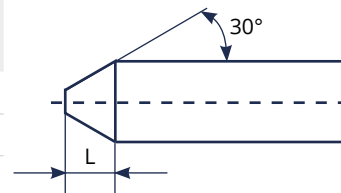
Nominal diameter (mm)		TOLERANCES		
from	to included	Class A	Class B	Class C
6	10	0 - 0.06	0 - 0.036	0 - 0.025
10	18	0 - 0.07	0 - 0.043	
18	30	0 - 0.08	0 - 0.052	
30	50	0 - 0.16		
50	80	0 - 0.19		

The standard tolerance for the round bar is Class A. Any different tolerances must be agreed upon when ordering
Semi-finished products can be supplied from Ø63 to Ø80 mm with Class A tolerances

Diameter (mm)		Length of bar (mm)	Tolerance (mm)	Diameter or Key (mm)		Deviation from straightness in mm	
						Every 400 mm	Every m of length L ≥ 1
2	30	3000 o 4000	+/- 50	Round section bar			
30	50	3000 o 4000	+/- 100				
50	80	3000	+/- 100	10	50	0.4	1.0 x L

BAR FINISHING AND PACKAGING

Diameter (mm)		Chamfer Length L mm		Tip Length L mm	
5	10	0.2	1.5	2	7
10	20	0.2	2	3	10
20	30	0.2	3	4	12



Unless otherwise specified by the buyer, the shape of the ends of products larger than 30 mm is up to the supplier

Ends of round bars	finishing with chamfer and tip up to and including Ø40 mm finishing with chamfer and cut greater than Ø40 mm
Bar surface	pickled
Packaging	1000 kg bundle – 3/5 metal straps different bundle packagings and quantities are possible upon request
Identification	adhesive label on bundle strap
Stress relieving	the polygonal bar was subjected to stress relieving treatment



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