

## CuSi 3 Laser brazing -welding wire

**CATEGORY** Laser welding wires

**TYPE** Copper-Silicon filler metal for Laser brazing.

**APPLICATIONS** Brazing thin plates and or galvanized plates in the car industry and also for cladding CuMn, CuSiMn and CuZn alloys. Suitable for cladding cast iron and un- and low alloyed steels. Examples: Automobile industry, art work, cladding on steel, cast iron and copper alloys etc.

**PROPERTIES**

- High quality alloyed copper wire designed for laser welding and brazing
- The deposit is a Copper- Silicon bronze
- Sound, pore free deposits on ferrous and non-ferrous base materials
- Excellent corrosion resistance.

**CLASSIFICATION**

AWS	A 5.7: ER CuSi-A
EN ISO	24373: Cu 6560
DIN: W.Nr.	2.1461
DIN	1733: SG-CuSi3

**SUITABLE FOR** Joining thin steel plates and or galvanized plates in the car industry and also for cladding CuMn, CuSiMn and CuZn alloys. Suitable for cladding cast iron and un- and low alloyed steels.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**FILLER METAL ANALYSIS % (TYPICAL VALUES)**

Cu	Mn	Si	Other
bal	0.75-0.95	2.80-2.95	<0.50

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0.2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
none	350						80

**WELDING PARAMETERS PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / Spools /Drums	kg / pallet
0.8	21-23	130-150	D-200 / K-300 / D-300	5 / 15 / 250	1000 / 1080 / 1000
1.0	23-25	145-185	D-200 / K-300 / D-300	5 / 15 / 250	1000 / 1080 / 1000
1.2	26-28	195-215	D-200 / K-300 / D-300	5 / 15 / 250	1000 / 1080 / 1000

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I, Ar/He (70-30)