

## CuSi 3 Tig

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Copper-Silicon welding wire for Tig welding

**APPLICATIONS** Welding 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 for the Tig process (Mig brazing as well)
  - The weld metal 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** Welding 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.

**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> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	350						80

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing	
	Current (A) (DC-)		single (kg)	master (kg)
1.6 x 1000	70-150		5	25
2.0 x 1000	125-175		5	25
2.4 x 1000	150-200		5	25
3.2 x 1000	230-400		5	25
4.0 x 1000	325-500		5	25

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I