

CuSiMn Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Copper-Silicon-Manganese alloy for Tig welding

APPLICATIONS Welding CuMn, CuSiMn, pure copper and copper alloys.

PROPERTIES Good flowing alloy with less pores and excellent de-oxidation properties.

CLASSIFICATION
 AWS A 5.7: no standard
 EN ISO 24373: no standard
 DIN 1733: no standard

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	Sn	Mn	P	Si
bal	<0.1	0.1-0.4	<0.015	0.1-0.4

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V -20°C	Density (Kg/dm ³)	Melting range °C	Hardness HB
AW		250			8.9	1020-1050	

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

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1