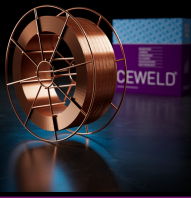


# CEWELD CuSi3

| TYPE  | CuSi3, Copper-Silicon wire for Mig brazing / 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  | <ul style="list-style-type: none"> <li>• High quality alloyed copper wire for the Tig process (Mig brazing as well)</li> <li>• The weld metal is a Copper- Silicon bronze</li> <li>• Sound, pore free deposits on ferrous and non-ferrous base materials</li> <li>• Excellent corrosion resistance Best to be used with pulsed welding!</li> </ul>   |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| CLASSIFICATION                                    | <table border="0"> <tr> <td>AWS</td> <td>A 5.7: ERCuSi-A</td> </tr> <tr> <td>EN ISO</td> <td>24373: Cu 6560 / CuSi3Mn1</td> </tr> <tr> <td>W.Nr.</td> <td>2.1461</td> </tr> <tr> <td>F-nr</td> <td>32</td> </tr> </table>  | AWS            | A 5.7: ERCuSi-A         | EN ISO               | 24373: Cu 6560 / CuSi3Mn1 | W.Nr.                   | 2.1461             | F-nr     | 32                      |     |           |     |      |     |      |     |       |
| AWS   | A 5.7: ERCuSi-A  |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| EN ISO  | 24373: Cu 6560 / CuSi3Mn1  |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| W.Nr.   | 2.1461   |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| F-nr  | 32   |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| SUITABLE FOR                                      | <p>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.</p> <p>Sislicon Alloy:</p> <p>2.0220 - CuZn 5,<br/>         2.0230 - CuZn 10,<br/>         2.0240 - CuZn 15,<br/>         2.1322 - CuMg 0,4,<br/>         2.1323 - CuMg 0,7</p>  |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| APPROVALS   |  |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| WELDING POSITIONS                                 |  |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Si</th> <th>Mn</th> <th>Fe</th> <th>Cu</th> <th>Zn</th> <th>Pb</th> <th>Sn</th> <th>Al</th> </tr> </thead> <tbody> <tr> <td>3.5</td> <td>1</td> <td>0.3</td> <td>Rem.</td> <td>0.8</td> <td>0.01</td> <td>0.5</td> <td>0.005</td> </tr> </tbody> </table>  | Si             | Mn                      | Fe                   | Cu                        | Zn                      | Pb                 | Sn       | Al                      | 3.5 | 1         | 0.3 | Rem. | 0.8 | 0.01 | 0.5 | 0.005 |
| Si  | Mn   | Fe             | Cu                      | Zn                   | Pb                        | Sn                      | Al                 |          |                         |     |           |     |      |     |      |     |       |
| 3.5   | 1  | 0.3            | Rem.                    | 0.8                  | 0.01                      | 0.5                     | 0.005              |          |                         |     |           |     |      |     |      |     |       |
| MECHANICAL PROPERTIES                             | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>p0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td>350</td> <td>40</td> <td colspan="2">60</td> <td>80 HB</td> </tr> </tbody> </table> | Heat Treatment | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%)        | Impact Energy (J) ISO-V |                    | Hardness | RT                      |     | As Welded |     | 350  | 40  | 60   |     | 80 HB |
| Heat Treatment                                    | R <sub>p0,2</sub> (MPa)  |                |                         |                      |                           | R <sub>m</sub> (MPa)    | A <sub>5</sub> (%) |          | Impact Energy (J) ISO-V |     | Hardness  |     |      |     |      |     |       |
|   |  | RT             |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| As Welded   |  | 350            | 40                      | 60                   |                           | 80 HB                   |                    |          |                         |     |           |     |      |     |      |     |       |
| REDRYING  | Not required   |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |
| GAS ACC. EN ISO 14175                             | I1, I3   |                |                         |                      |                           |                         |                    |          |                         |     |           |     |      |     |      |     |       |



# CEWELD CuSi3

## CUSI3 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663408204 |
| D-200     | 5       | 8720663408235 |
| D-200     | 5       | 8720663408211 |
| D-300     | 15      | 8720663408228 |

## CUSI3 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663408242 |
| D-200     | 5       | 8720663408259 |
| D-300     | 15      | 8720663408266 |
| Drum      | 250     | 8720663408303 |

## CUSI3 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663408273 |
| D-200     | 5       | 8720663408280 |
| Drum      | 250     | 8720663408297 |