



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

- 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 Best to be used with pulsed welding!

CLASSIFICATION

AWS	A 5.7: ERCuSi-A
EN ISO	24373: Cu 6560 / CuSi3Mn1
W.Nr.	2.1461
F-nr	32

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.

Sislicon Alloy:

- 2.0220 - CuZn 5,
- 2.0230 - CuZn 10,
- 2.0240 - CuZn 15,
- 2.1322 - CuMg 0,4,
- 2.1323 - CuMg 0,7

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Si	Mn	Fe	Cu	Zn	Pb	Sn	Al
3.5	1	0.3	Rem.	0.8	0.01	0.5	0.005

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	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