



# 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.<br>Sislicon Alloy:<br>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                                                                                                                                                                                                                                                                                                                                                                                        |                           |                      |                    |                         |      |     |          |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                           |                      |                    |                         |      |     |          |
| WELDING POSITIONS                                 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> <div> PG</div> |                           |                      |                    |                         |      |     |          |
| 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 <sub>P0,2</sub> (MPa)   | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |      |     | Hardness |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                           | 350                  | 40                 | RT                      |      |     |          |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                           |                      |                    | 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 |