

# CEWELD CuSi 3 Laser brazing -welding wire

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                           |             |          |        |          |       |      |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|-------------|----------|--------|----------|-------|------|
| TYPE                                              | Copper-Silicon filler metal for Laser brazing.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                           |             |          |        |          |       |      |
| TOEPASSINGEN                                      | Brazing 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.                                                                                                                                                                                                                                                                                                             |                           |             |          |        |          |       |      |
| EIGENSCHAPPEN                                     | High quality alloyed copper wire designed for laser welding and brazing. The deposit is a Copper-Silicon bronze. Sound, pore free deposits on ferrous and non-ferrous base materials. Excellent corrosion resistance.                                                                                                                                                                                                                                                                                                                                                                         |                           |             |          |        |          |       |      |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | A 5.7: ERCuSi-A           |             |          |        |          |       |      |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 24373: Cu 6560 / CuSi3Mn1 |             |          |        |          |       |      |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 2.1461                    |             |          |        |          |       |      |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 32                        |             |          |        |          |       |      |
| GESCHIKT VOOR                                     | Joining 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.                                                                                                                                                                                                                                                                                                                                                                                                    |                           |             |          |        |          |       |      |
| GOEDKEURINGEN                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                           |             |          |        |          |       |      |
| LASPOSITIES                                       |        |                           |             |          |        |          |       |      |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Mn                        | Fe          | Zn       | Pb     | Sn       | Al    | Cu   |
|                                                   | 3.5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 1                         | 0.3         | 0.8      | 0.01   | 0.5      | 0.005 | Rem. |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                           | RP0,2 (MPa) | Rm (MPa) | A5 (%) | Hardness |       |      |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                           |             | 350      |        | 80 HB    |       |      |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                           |             |          |        |          |       |      |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                           |             |          |        |          |       |      |