

Cu-base solid wire

Classification

AWS A5.7	: ERCuSi-A
EN 14640	: S Cu 6560 (CuSi3Mn1)

General description

Solid wire for GMA-welding of low-alloyed copper grades
High temperature and corrosion resistant

Shielding gases (acc. ISO 14175)

I1	Inert gas Ar (100%)
I3	Inert gas Ar+ 0.5-95% He

Chemical composition (w%) typical wire

Cu	Mn	Si	Sn	Zn
bal.	1.0	3.0	0.1	0.1

Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C	Hardness HB
Typical values	I1	AW	120	350	40	60	95

Materials to be welded

Copper, low alloyed copper and copper-zinc alloys

Packaging and available sizes

Unit type	Diameter (mm)	
	0.8	1.0
5 kg spool BS300	X	X
12 kg spool B300		X
Other sizes and packaging on request		

LNМ CuSi3: rev. EN 01

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request

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