

CEWELD CuSi3

certilas® THE FILLER METAL SPECIALIST

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)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded		350	40	60	80 HB

REDRYING

Not required

GAS ACC. EN ISO 14175

I1, I3