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
F-nr	32
W.Nr.	2.1461

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: No Approvals Found

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

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Hardness Brinell Hardness
As Welded /		350	40	60	Avg. 80

REDRYING TEMPERATURE: Not required

GAS ACCORDING EN 14175: I1, I3

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CUSI3 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663408204
D-200	5	8720663408235
D-200	5	8720663408211
D-300	15	8720663408228

CUSI3 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663408242
D-200	5	8720663408259
D-300	15	8720663408266
Drum	250	8720663408303

CUSI3 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663408273
D-200	5	8720663408280
Drum	250	8720663408297