



CEWELD CuSi3 Tig

TYPE	Copper-Silicon welding wire for 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	<ul style="list-style-type: none"> • 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 										
CLASSIFICATION	<table border="0" style="width: 100%;"> <tr> <td style="width: 30%;">AWS</td> <td>A 5.7: ERCuSi-A</td> </tr> <tr> <td>EN ISO</td> <td>24373: Cu 6560 / CuSi3Mn1</td> </tr> <tr> <td>W.Nr.</td> <td>2.1461</td> </tr> <tr> <td>F-nr</td> <td>32</td> </tr> </table>	AWS	A 5.7: ERCuSi-A	EN ISO	24373: Cu 6560 / CuSi3Mn1	W.Nr.	2.1461	F-nr	32		
AWS	A 5.7: ERCuSi-A										
EN ISO	24373: Cu 6560 / CuSi3Mn1										
W.Nr.	2.1461										
F-nr	32										
SUITABLE FOR	<p>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.</p> <p>Sislicon Alloy:</p> <p>2.0220 - CuZn 5, 2.0230 - CuZn 10, 2.0240 - CuZn 15, 2.1322 - CuMg 0,4, 2.1323 - CuMg 0,7</p>										
APPROVALS											
WELDING POSITIONS											
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 33%;">Si</td> <td style="width: 33%;">Mn</td> <td style="width: 33%;">Cu</td> </tr> <tr> <td>2.95</td> <td>0.9</td> <td>Rem.</td> </tr> </table>	Si	Mn	Cu	2.95	0.9	Rem.				
Si	Mn	Cu									
2.95	0.9	Rem.									
MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Heat Treatment</td> <td style="width: 15%;">R_{P0,2} (MPa)</td> <td style="width: 15%;">R_m (MPa)</td> <td style="width: 15%;">A₅ (%)</td> <td style="width: 30%;">Hardness</td> </tr> <tr> <td>As Welded</td> <td></td> <td>350</td> <td></td> <td>80 HB</td> </tr> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded		350		80 HB
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness							
As Welded		350		80 HB							
REDRYING	Not required										
GAS ACC. EN ISO 14175	I1, I3										



CEWELD CuSi3 Tig

CUSI3 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663408310
CUSI3 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663408327
CUSI3 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663408334
CUSI3 TIG 3,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663408341
CUSI3 TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663408358
CUSI3 TIG 4,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663408365