

Cu Si 3 W/R

AWS A5.7 / A5.8: ERcCuSi-A
EN ISO 24373 – S Cu 6560 (CuSi3Mn1)

Description: Copper Si alloy, with a controlled Si content (2.80%-3.20) in order to avoid welding defects. For GMAW/GTAW welding on low-alloyed CuMn, CuSiMn and CuZn materials. High temperature and corrosion resistance. Thanks to its melting range and weldability this alloy reduce the finishing operation after welding.

Application: Suitable to weld oxygen-free copper and Cu materials. Used also for galvanized steel GMAW brazing and laser brazing. In case of high thickness, it is recommended to preheat to 300 °C.

Chemical composition according to EN ISO 24373 [%]:

	Cu	Al	Fe	Mn	Ni ¹	P	Pb	Si	Sn	Zn	As	C	Ti	S	other total
min.	rem.	-	-	0.50	-	-	-	2.80	-	-	-	-	-	-	-
max.	-	0.02	0.50	1.50	-	0.05	0.02	4.00	0.20	0.40	-	-	-	-	0.50

Remark: maximum value unless shown as a range or a minimum. ¹ including Co

Mechanical and Physical properties: (as-welded)

min R _m [N/mm ²]	350
A [%]	40
Electric Conductivity [m/Ω·mm ²]	3.5 – 4.0
Brinell Hardness [HB 2,5/62,5]	80
T melting [°C]	910 - 1025

Available sizes:

Wire: diam. 0.80-1.00-1.20-1.60 mm

Spools:

D100 1,0 kg plastic spool

D200 2,0 – 5,0 kg plastic spool

D300 15,0 kg plastic spool

BS300 15,0 kg basket spool

Drums:

200 kg

Rods: diam 1.60-2.00-2.40-3.20-4.00 mm x 1000 mm

10 kg cardboard box

Both wire and rods available in FIDAT boxes or neutral boxes

Gas: EN ISO 439 – I1 (Ar), I3 (He,Ar)

Winding: precision layer wound wire