



AUTOBRAZE CuSi

GMAW COPPER ALLOYS

AWS A/SFA 5.7 **ERCuSi-A**

CLASSIFICATION:

EN ISO 24373

SCu 6560 (Cu Si3 Mn1)

DIN 1733

SG-CuSi3

KEY FEATURES:

- Copper-Silicon solid wire
- Weld pool should be kept small in order to promote fast solidification and minimize cracking
- Preheating is not recommended
- Interpass temperature to be kept below 65°C
- Excellent for plain or galvanized steel sheet metal and other coated steels
- Radiographic quality welds

TYPICAL APPLICATIONS:

- Welding of copper-silicon and copper-zinc base metals to themselves and to steels
- Used for surfacing areas that are subjected to corrosion



CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

Zn	Sn	Mn	Fe	Si	Al	Pb	Cu+Ag
1.0 max	1.0 max	1.5 max	0.5 max	2.8-4.0	0.01 max	0.02 max	Bal.

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	Average Brinell Hardness, HBW
Specification	As Welded	345 min	80-100

PARAMETERS - PACKING DATA:

Ø x L, mm	Kg/Spool		
0.8	12.5	 DCEP STORAGE / HANDLING : Keep dry during storage and handling	All Positions 
1.0	12.5		
1.2	12.5		
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
75Ar/25He	15-20