

CEWELD CuSi 3 Laser brazing -welding wire

TYPE	Copper-Silicon filler metal for Laser brazing.								
APPLICATIONS	Brazing 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.								
PROPRIÉTÉS	High quality alloyed copper wire designed for laser welding and brazing. The deposit is a Copper-Silicon bronze. Sound, pore free deposits on ferrous and non-ferrous base materials. Excellent corrosion resistance.								
CLASSIFICATION	<table border="0"> <tr> <td>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
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EN ISO	24373: Cu 6560 / CuSi3Mn1								
W.Nr.	2.1461								
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CONVIENT POUR	Joining 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.								

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)

Si	Mn	Fe	Zn	Pb	Sn	Al	Cu
3.5	1	0.3	0.8	0.01	0.5	0.005	Rem.

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded		350		80 HB

ETUVAGE Not required

GAS ACC. EN ISO 14175 11