

## ML CuSi3

### Rod/Wire electrode for Copper

<b>Typical composition in %</b>	Al ..... < 0,02 Si ..... 2,80-4,00 Mn ..... 0,50-1,50 Sn ..... < 0,20 Zn ..... < 0,40 Pb ..... < 0,02 Fe ..... < 0,50 P ..... < 0,05 Others total ..... < 0,50
<b>Classification</b>	ISO 24373 ..... S Cu 6560 (CuSi3Mn1) DIN 1733 ..... SG-CuSi3 Material No. .... 2.1461 BS 2901 Part 3 ..... C 9 AWS A 5.7 ..... ER CuSi – A
<b>Base materials</b>	CuZn5; CuZn10; CuZn15; CuSi2Mn; CuSi3Mn
<b>Remarks</b>	Filler wire for joining copper, copper-silicon and copper-zinc alloys. Suitable for joining of steel to copper and for surfacing of steel. High temperature and corrosion resistance. Very commonly used for galvanized steel.
<b>Physical properties (Approx. values)</b>	Electrical conductivity [S*m/mm <sup>2</sup> ] ..... 3-4 Density [kg/dm <sup>3</sup> ] ..... 8,5 Solidus-Temperature [°C] ..... 910 Liquidus-Temperature [°C] ..... 1025 Tensile strength R <sub>m</sub> [MPa] ..... 330 - 370 Elongation A <sub>5</sub> (L <sub>0</sub> =5d <sub>0</sub> ) [%] ..... 40 Hardness [HB] ..... 80 - 90
<b>Welding position</b>	PA, PB, PC, PE, PF
<b>Shielding gas</b>	I1, I2, I3 (Argon, Helium or Argon/Helium-mixtures)
<b>Polarity</b>	MIG =+, TIG -
<b>Dimensions Ø</b>	MIG-wires [mm] ..... 0,8; 1,0; 1,2; 1,6; 2,0; 2,4; 3,2 TIG-rods [mm] ..... 1,6; 2,0; 2,4; 3,2; 4,0
<b>Wire packagings</b>	Spools ..... Packaging units S 200 / 5 kg ..... n/a S 300 / 15 kg ..... 25 spools = 375 kg (pallet) B 300 / 3 kg ..... n/a B 300 / BS 300 / 15 kg ..... 25 spools = 375 kg (pallet) Eco-drum / 200 kg ..... 2 drums = 400 kg (pallet)
<b>Rod packagings</b>	Box 10 kg ..... Length 1.000 mm