

ML CuSi3

Rod/Wire electrode for Copper

Typical composition in %	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
Classification	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
Base materials	CuZn5; CuZn10; CuZn15; CuSi2Mn; CuSi3Mn
Remarks	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.
Physical properties (Approx. values)	Electrical conductivity [S*m/mm ²] 3-4 Density [kg/dm ³] 8,5 Solidus-Temperature [°C] 910 Liquidus-Temperature [°C] 1025 Tensile strength R _m [MPa] 330 - 370 Elongation A ₅ (L ₀ =5d ₀) [%] 40 Hardness [HB] 80 - 90
Welding position	PA, PB, PC, PE, PF
Shielding gas	I1, I2, I3 (Argon, Helium or Argon/Helium-mixtures)
Polarity	MIG =+, TIG -
Dimensions Ø	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
Wire packagings	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)
Rod packagings	Box 10 kg Length 1.000 mm