



# MIG CUSIL

Old reference: MIG CuSi3

## Classification

AWS A5.7 : ER CuSi-A

ISO 24373 : S Cu 6560 (CuSi3Mn1)

## Description & Applications

Solid wire for GMAW of Cu-Si and Cu-Mn alloys. Also used for heterogenous assemblies between Cu-Si or Cu-Mn alloys and steels or galvanised steels.

**Main applications:** Automotive Industrie.

## Typical Chemical Composition ( % )

	Al	Fe	Mn	P	Pb	Si	Sn	Zn	O/T	Cu
Min			0.5			2.8				
Max	0.01	0.50	1.5	0.05	0.02	4.0	0.2	0.4	0.50	Rem.
Type	0.001	0.01	1.0	0.001	0.01	3.0	0.01	0.05	<0.50	Rem.

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
Min	-	-	-
Max			
Type	150	350	42

## Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	120 - 180	20 - 22	ISO 14175: I1 (100% Ar) I2 (100% He) I3 (Ar+ 5-30%He) 12-18 l/min
	1.0	180 - 220	22 - 24	
	1.2	220 - 250	24 - 26	

Preheating of massive parts between 200°C (>6mm) up to 500°C (>15mm).

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**Fumes:** Consult information on MSDS, available upon request.

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