MIG CUSIL

Old reference: MIG CuSi3

Classification

AWS A5.7 : ERCuSi-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

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
Min	-	-	-
Max			
Type	150	350	42

Welding Current & Instructions

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

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