



TIG CUSIL

Old reference: TIG CuSi3

Classification

AWS A5.7 : ERCuSi-A

ISO 24373 : S Cu 6560 (CuSi3Mn1)

Description & Applications

Solid rod for GTAW 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	360	42

Welding Current & Instructions

Welding mode	Shielding Gas
GTAW = -	ISO 14175: I1 (100% Ar) / I2 (100% He) / I3 (Ar+ 5-30%He) 5-10 L/min

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

FT En-TU05-170220

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group.

Fumes: Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr