

CEWELD CuSi 3 Laser brazing -welding wire

TYPE	Copper-Silicon filler metal for Laser brazing.							
APPLICATIONS	Brazing thin plates and or galvanized plates in the car industry and also for cladding CuMn, CuSiMn and CuZn alloys. Suitable for cladding cast iron and un- and low alloyed steels. Examples: Automobile industry, art work, cladding on steel, cast iron and copper alloys etc.							
PROPRIÉTÉS	High quality alloyed copper wire designed for laser welding and brazing. The deposit is a Copper-Silicon bronze. Sound, pore free deposits on ferrous and non-ferrous base materials. Excellent corrosion resistance.							
CLASSIFICATION	AWS	A 5.7: ERCuSi-A						
	EN ISO	24373: Cu 6560 / CuSi3Mn1						
	W.Nr.	2.1461						
	F-nr	32						
CONVIENT POUR	Joining thin steel plates and or galvanized plates in the car industry and also for cladding CuMn, CuSiMn and CuZn alloys. Suitable for cladding cast iron and un- and low alloyed steels.							
AGRÉMENTS								
POSITIONS DE SOUDAGE								
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	Si	Mn	Fe	Zn	Pb	Sn	Al	Cu
	3.5	1	0.3	0.8	0.01	0.5	0.005	Rem.
PROPRIÉTÉS MÉCANIQUES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)		A5 (%)	Hardness	
	As Welded			350			80 HB	
ETUVAGE	Not required							
GAS ACC. EN ISO 14175	I1							