TIG rod / Solid wire
Copper

AX-CuSi3

Material-No.: 2.1461

Standards

EN ISO 24373:	S Cu 6560 (CuSi3Mn1)
AWS A5.7:	ERCuSi-A

Properties

TIG-rod/solid wire made of copper-silicon alloy with low melting point for TIG or MIG welding (brazing) of galvanized steel sheets in car body construction. The corrosion protection of galvanized surfaces is largely preserved.

Important base materials / Important applications

Galvanized steel sheets and copper-silicon and copper-manganese alloys of the same type, e.g. CuSi2Mn, CuSi3Mn.

Typical composition of welding rod / solid wire in %

Cu	Si	Sn	Fe	Mn
Basis	2,9	0,01	0,06	0,9

Mechanical properties of all-weld metal (typical values)

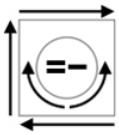
Yield strength $R_{p0,2}$	[MPa]	120	
Tensile strength R_m	[MPa]	350	
Elongation A ($L_0 = 5d_0$)	[%]	40	
Impact work KV	[J]	60	at +20°C
Hardness	[HB]	80	
Thermal conductivity	[W/(m*K)]	35	

Shielding gas: 100% Argon, PWHT: untreated

Operating data

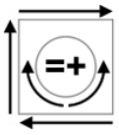
TIG:

Shielding gas: I1 (100%Argon)
acc. to ISO 14175



GMAW:

I1 (100%Argon)
I3 (e.g. Ar+30%He)



Preheating of the base material is usually not necessary. Ensure low heat input. Short arc / pulse process is recommended for MIG welding.

Approvals

(Please ask for current scope)

Packaging and available sizes

Spools	Ø mm	0,8	1,0	1,2	1,6		
Rods	Ø mm x 1000mm	1,6	2,0	2,4	3,2	4,0	

Other dimensions on request.