LNM CuSi3

CLASSIFICATION

AWS A5.7 - ERCuSi-A
EN 14640 - S Cu 6560 (CuSi3Mn1)

GENERAL DESCRIPTION

Solid wire for GMA-welding of low-alloyed copper grades
High temperature and corrosion resistant

WELDING POSITIONS

ISO/ASME

PA/1G PB/2F PC/2G PD/4F PE/4G PF/3G up

SHIELDING GASES (ACC. ISO 14175)

I1	Inert gas Ar (100%)
I3	Inert gas Ar+ 0.5-95% He

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

Cu	Sn	Mn	Si	Zn
bal.	0.1	1.0	3.0	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yiield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Hardness HB	Impact ISO-V(J) +20°C
Typical values	I1	AW	120	350	40	95	60

MATERIALS TO BE WELDED

Copper, low alloyed copper and copper-zinc alloys

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	0.8	1.0	1.2
Unit :	5 kg spool S200	X		
	12 kg spool BS300	X	X	X

Other sizes and packaging on request

LNM CuSi3: rev. EN 02

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