

LNM CuSi3

CLASSIFICATION

AWS A5.7	ERCuSi-A	A-Nr	-	Mat-Nr	2.1461
EN ISO 24373	S Cu 6560 (CuSi3Mn)	F-Nr	32		
		9606 FM	-		

GENERAL DESCRIPTION

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

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

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	Yield 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

EXAMPLES OF MATERIALS TO BE WELDED

Copper, low alloy copper and copper-zinc alloys

PACKAGING AND AVAILABLE SIZES

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

Other sizes and packaging on request

LNM CuSi3: rev. C-EN03-01/02/16