



## CLASSIFICATIONS

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

## KEY FEATURES AND APPLICATIONS

- Solid copper-silicon wire used primarily for corrosion-resistant surfaces.
- Ideal for welding thin plates and or galvanized plates on car body panels.
- Suitable for cladding cast iron and un- and low alloyed steels.
- Depending on the base material thickness, preheating may be required.
- Typically used in the automotive industry, coatings on low-alloy steels, solenoid valves and switch cabinets etc.

## BASE MATERIALS

2.0220 - CuZn 5, 2.0230 - CuZn 10, 2.0240 - CuZn 15, 2.1322 - CuMg 0,4, 2.1323 - CuMg 0,7

## CHEMICAL COMPOSITION OF WIRE %

	Cu	Al	Fe	Mn	P	Pb	Si	Sn	Zn	Others
MIN	Bal.	-	-	0.5	-	-	2.8	-	-	-
MAX		0.02	0.5	1.5	0.05	0.02	4.0	0.2	0.4	0.5

Single values are maximum values according to EN ISO 24373

## MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Tensile Strength (MPa)	Hardness (HB)	Melting Temperature
≥345	≥80	965 - 1035°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

## OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1, I3	DC-

## PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP40325	1.6	1000	5	PAP 20 Tube
XP40326	2.4	1000	5	PAP 20 Tube
XP40327	3.2	1000	5	PAP 20 Tube