

Cu-base solid wire

Classification

AWS A5.7-84R : ERCuSi-A
DIN 1733-88 : SG-CuSi3

General description

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

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
	I3	Inert gas Ar+ >0-95% He

Approvals

GTAW

Chemical composition (w%), typical, rod

Cu	Mn	Si	Sn	Zn
bal.	1.0	3.0	0.1	0.1

Mechanical properties, typical, all weld metal

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

Materials to be welded

Copper, low alloyed copper and copper-zinc alloys

Packaging

Process	Unit	Sizes (mm)	2.0	2.4
GTAW	2 kg tube		X	X

Other sizes and packaging on request

LNT CuSi 3: rev. EN 15