# MIG CUSIL

*Old reference*: MIG CuSi3

## Classification

ISO 24373 : S Cu 6560 (CuSi3Mn1) Material N° : 2.1461
AWS A5.7 : ERCuSi-A

## Description & Applications

Solid wire for GMAW, especially recommended for welding of bronzes and MIG-brazing of galvanized sheets.

**Main applications:** Automotive industry.

## Typical Chemical Composition ( % )

| Sn | Mn | Si | Zn | Al | Pb | Cu |
|---|---|---|---|---|---|---|
| 0.8 | 1.0 | 3.0 | <0.1 | <0.01 | <0.02 | Rem. |

## All Weld Metal Mechanical Properties

| $R_{p0.2}$ ( MPa ) | $R_m$ ( MPa ) | $A_5$ ( % ) |
|---|---|---|
| 150 | 350 | 42 |

## Welding Current & Instructions

| Welding mode | Wire Ø (mm) | Welding parameters | | Shielding Gas |
|---|---|---|---|---|
| | | Pulsed arc (A) | (V) | |
| MIG = + | | | | Ar+2,5%$CO_2$ |

Preheating at 200 to 300°C is advised to massive parts.

Ind.10

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