



MIG / TIG CuSi3

COPPER ALLOY

DESCRIPTION

Silicon bronze alloy solid **GMAW (MIG)** or **GTAW (TIG)** wire for welding copper, copper alloys and galvanized steels. Also recommended for overlaying surfaces subjected to corrosion or wear.

CHARACTERISTICS

- Excellent for welding galvanized steels
- High copper content deposit
- Conform to standard AWS A5.7 : ERcCuSi-A
- Very good mechanical properties
- Excellent corrosion resistance

TYPICAL APPLICATIONS

Galvanized steels, cast copper parts, hydraulic and electrical installations, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the joint area. While preheating is generally required for copper, welding of steel is carried out without any preheat. A maximum interpass temperature of 100°C (212°F) is recommended between layers, based on thickness.

MECHANICAL PROPERTIES

Tensile strength: 350 MPa (50 000 psi)
 Yield strength: 160 MPa (23 000 psi)
 Elongation: 45 %
 Hardness: 70 - 80 BH

WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas flow	Gas
GMAW MIG	0.6 mm (.024")	18 - 23	80 - 130	30 à 50 CFH	100 % Argon or Argon + Helium
	0.8 mm (.030")	20 - 25	80 - 180		
	0.9 mm (.035")	22 - 26	100 - 200		
	1.2 mm (.045")	26 - 28	150 - 250		
GTAW TIG	1.6 mm (1/16")	CC-		30 à 40 CFH	100 % Argon or Argon + Helium
	2.5 mm (3/32")				
	3.2 mm (1/8")				

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