

# AX-CuSi3 2.1461

## Standard

EN ISO 24373	S-Cu 6560 (CuSi3Mn1)
Material number	2.1461
AWS A.5-7	ERCuSi-A

## Area of application

Filler rod/filler wire of copper-silicon-alloy with low melting point for TIG or MIG welding (soldering) of galvanized steel panels in car body construction. The corrosion proofing of galvanized surfaces remains very largely maintained.

## Special hints

Preheating of the base material is not required as a rule. Do not keep weld pool too wide. Take care to introduce little heat, when MIG welding in short electric arc/ pulsed arc process, when TIG welding introduce as much weld metal as possible.

## Composition of the filler rod/filler wire (typical data in %)

Cu	Si	Sn	Fe	Mn			
Bal.	3	0.1	0.07	1.0			

## Important base materials

Galvanized steel sheets and copper-silicon and copper-manganese-alloys of similar composition, such as CuSi2Mn, CuSi3Mn.

## Material properties

Shielding gas	Argon	Mechanical properties of the weld metal according to EN ISO 15792-1
Heat treatment	untreated	
Test temperature	20°C	
0.2%-yield strength $R_{p0.2}$	[MPa]	120
Tensile strength $R_m$	[MPa]	350
Elongation $A (L = 5d_0)$ [%]	[%]	40
Brinell hardness	[HB]	80
Impact strength $A_v$	[J]	60
Thermal conductivity	[W/(m*K)]	35

## Applicable shielding gases (EN ISO 14175)

TIG: argon I1, MIG: argon I1, I3

## Approvals

(Request current scope if required)

## Product forms (other dimensions available on request)

Spool/drum	Ø mm	0.8	1.0	1.2	1.6		
Rods	Ø mm x 1000 mm	1.6	2.0	2.4	3.2	4.0	