CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO S- CuSi 3
CARBO T- CuSi 3

International standards

	S = solid wire	T = bare rod
Material No.	2.1461	
DIN 1733	SG – CuSi3	SG – CuSi3
AWS A 5.7	ER CuSi-A	ER CuSi-A

Approvals --- ---

Application notes

High quality alloyed copper wire for welding CuMn, CuSiMn and CuZn alloys (Mig brazing as well). Suitable for cladding cast iron and un- and low alloyed steels. Temperature and corrosion resistant.
Welding thin plates or galvanized plates in the car industry.

Base material

2.0090, 2.0230, 2.0240, 2.0241, 2.026, 2.0360

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R_m N/mm²	Yielding strength $R_{p0,2}$ N/mm²	Impact strength ISO – V J at Rt.° C	Elongation A_5
350	120	60	40%

Hardness

80 HB

Weld metal analysis
(typical, wt %)

Cu	Mn	Sn	Si	Fe	Zn
Base	1,0	0,10	3,0	0,07	0,1

Gas types EN 439

S = solid wire	T = bare rod
I1-I3	I1

Current

		= +				= –				
Diameter	mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0

coils, weight

B300 15 kg. 10 kg./ carton

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