

## MCU Si3

Gas Metal Arc (MIG) Welding Wire - Copper Alloys

### Standards

AWS/ASME SFA - 5.7	ERCuSi-A
EN ISO 24373	S Cu 6560 (CuSi3Mn1)
TS EN ISO 24373	S Cu 6560 (CuSi3Mn1)
DIN M. No.	2.1461

### Properties and Applications

3% Silicon alloyed copper wire electrode for GMA (MIG) welding of copper(Cu), Cu-Si (silicon bronze), Cu-Zn (brass) and as well as surfacing of unalloyed or medium alloyed steels or cast irons. Due to less Zn burn and corrosion resistant weld metal, suitable for joining of galvanized steels. Resulted Zn burn is less and weld metal is corrosion resistant in galvanized steels. For large workpieces e.g. thicknesses exceeding 5 mm, a preheat at about 250°C is recommended.

### Typical Chemical Features of the Welding Wire

Type of Analysis	Si	Mn	Cu
Welding Wire	2.90	0.80	96.30

### Typical Physical Analysis of the Weld Metal

Özgül Ağırlığı (gr/cm <sup>3</sup> )	Elektrik İletkenliği (Sm/mm <sup>2</sup> )
0.00	0.25-0.28


### Typical Mechanical Values of Weld Metal


Test Condition	Protection Gas	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Hardness (HB)
As welded	I1	120	350	40	80


\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .


### Application Information


**Welding Positions**


  
PA

  
PB

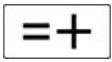
  
PC

  
PD

  
PE

  
PF

**Polarity:**



**Protection Gas:**  
I3 I1 I2

**Welding Parameters & Efficiency**

Diameter (mm)
0.80
1.00
1.20

### Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
25003B1GM2	0.80	200 kg	207.50	1	207.50	Fiber Drum
25003BAKM2	0.80	1 kg	1.10	14	15.70	Plastic Spool (D100)
25003BBAM2	0.80	5 kg	5.30	1	5.30	Plastic Spool (D200)
25003BHAM2	0.80	15 kg	15.80	1	15.80	Plastic Spool (D300)
25003D1GM2	1.00	200 kg	207.50	1	207.50	Fiber Drum
25003DAKM2	1.00	1 kg	1.10	14	15.70	Plastic Spool (D100)
25003DBAM2	1.00	5 kg	5.30	1	5.30	Plastic Spool (D200)
25003DHAM2	1.00	15 kg	15.80	1	15.80	Plastic Spool (D300)

25003EHAM2	1.20	15 kg	15.80	1	15.80	Plastic Spool (D300)
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**Storage & Re-Drying Information**

Shouldn't be exposed to high statical load and impact.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.