



(CuSi3Mn)

Cu-alloy wire electrode for MIG and TIG welding

Standard designation

ISO 24373 : Cu 6560 CuSi3Mn1

Composition (weight %)

Cu : balance
Mn : 0,75 - 0,95
Si : 2,80 - 2,95
Others : max. 0,5

Physical standard data

Density kg/dm³ : 8,5
Melting range ° C : 965-1035
Thermal conductivity W/m· K : 35
Coefficient of linear mean expansion (20°C-300°C) 1/ K : 18,1·10⁻⁶
Electric conductivity m/Ω·mm² : 3,5-4,0
Resistivity Ω·mm²/m : 0,25-0,286

Mechanical properties of the weld joint, standard data

Heat treatment non treated
Tensile strenght N/mm² : 350
Elongation % : 40
Brinell hardness HB 2,5/62,5 : 80
Notched bar impact test A_v (J) : 60

Range of application

Galvanized sheet-metal for car bodies in the automotive industry, for building up low-alloy steels, solenoid valves, switch cabinets

Recommendation

Applicable inert gas

Argon 4.8/ 5.0/ 5.3/ 5.6/ 6.0

Make up

Diameter: 0,80 – 0,889 - 1,00 - 1,20 – 1,60 - and 2,40 mm.
Spools: D 300, H 370 and wire basket spools (acc. to DIN 8559).
Rods: 2,00 - 6,00 mm Ø x 1000 mm.
Further make ups on request.