

**MCuSi3**

DC+

COPPER ALLOY**DESCRIPTION**

Silicon bronze alloy solid GMAW (MIG) 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 : ERCuSi-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: 50 000 psi (350 MPa)
 Yield strength: 23 000 psi (160 MPa)
 Elongation: 45 %
 Hardness: 70 - 80 BH

WELDING PARAMETERS

| | | | |
|------------|-------------------------------|----------------|----------------|
| Gas: | Pure Argon or Ar – He mixture | | |
| Diameter: | 1.2 mm (.045") | 0.9 mm (.035") | 0.8 mm (.030") |
| Amperage: | 150 - 250 A | 100 - 200 A | 80 - 180 A |
| Voltage: | 26 - 28 V | 22 - 26 V | 20 - 25 V |
| Stick-out: | 5/16" - 3/4" (8 - 19 mm) | | |
| Packaging: | 13.6 kg spool | | |

TIG rods also available: **Soudotec T562**

Rev.: 7_01

Specialized welding alloys and technology. For technical assistance or for ordering: