

Filler wire for welding Cu-Si alloys, Cu-Mn together or with common steels. MIG brazing of galvanised or zinc coated steels. It is recommended for the welding of copper and various steel sheets. It is particularly in use within the automotive industry (HSS steels, better wettability).

## Classification

**AWS A5.7: ERCuSi-A**  
**EN ISO 24373: S Cu 6560 (CuSi3Mn1)**  
**DIN 1733 SG-CuSi3**

## Applications

- Automotive,
- Assembling industries.

## Benefits

- High resistance to corrosion.
- Resistance to high temperature.

## Polarity

DC +

## Chemical properties

Cu %	Si %	Mn %	Sn %	Fe %	Zn %
Base	3.00	1.00	0.10	0.07	0.10

## Mechanical properties

Re	Rm	A 5 d	AV 20°C	Hardness
120 Mpa	350 Mpa	40 %	60 J	80 HB

## Recommendations

Gas protection is compliant with EN ISO 14175  
100% Argon (I1)

## Approval

TÜV, UDT



S100

S200

## Packaging

weight (kg)	Wire reel type		Wire diameter (mm)			
			Ø 0.6	Ø 0.8	Ø 1.0	Ø 1.2
1	S100	—	—	086692	—	—
2	—	—	—	077393	—	—
5	S200	—	—	086647	086654	—