

BERCOWELD[®] S3 (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/dm ³	: 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·mm ²	: 3,5-4,0
Resistivity	Ω·mm ² /m	: 0,25-0,286

Mechanical properties of the weld joint, standard data

Heat treatment		non treated
Tensile strenght	N/mm ²	: 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.

www.bercoweld.com