



| | | | | | | |
|---------------------|------------------------------|------------------------------|--------------------|------------------------|------------------------|---------------|
| Prepared by MALI | Qualified by Tero Tolonen | Approved by Michael Spieß | Reg no EN006217 | Cancelling EN002926 | Reg date 2013-09-13 | Page 1 (1) |
|---------------------|------------------------------|------------------------------|--------------------|------------------------|------------------------|---------------|

REASON FOR ISSUE

Update of classification and chemical composition.

GENERAL

Bare copper welding rods containing approx. 3 % Si used for joining of copper-silicon and copper-zinc base metals and similar. Can also be used for overlay welding of un- and low alloyed steels.

Shielding Gas: I1, I2, I3 (EN 439)

Alloy Type: Alloyed copper (Cu + 3 % Si)

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.7 ERCuSi-A
EN ISO 24373 CuSi3Mn1

APPROVALS

Not applicable

CHEMICAL COMPOSITION

Wire/Strip (%)

| | Min | Max |
|------------|------|------|
| Si | 2.8 | 4.0 |
| Mn | 0.5 | 1.5 |
| P | | 0.05 |
| Cu | 94.0 | |
| Al | | 0.02 |
| Sn | | 0.2 |
| Pb | | 0.02 |
| Zn | | 0.4 |
| Fe | | 0.5 |
| Ni+Co | | 0.10 |
| Others tot | | 0.5 |

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

| Properties | As welded | |
|-------------|-----------|--|
| | Typ | |
| Rp0.2 (MPa) | 150 | |
| Rm (MPa) | 350 | |
| A4-A5 (%) | 40 | |