

FONTARGEN A 202 MS

Copper-silicon wire electrode for laser brazing



ISO 24373: S Cu 6560 (CuSi3Mn1)
AWS A 5.7: ERCuSi-A
Material-no.: 2.1461

Composition, typical analysis (% w/w):

Si	Sn	Zn	Mn	Fe	Cu
2.9	0.1	0.1	1.2	0.2	Remainder

Characteristics / Applications:

Laser-brazing of zinc-galvanised, aluminized and uncoated steel plates.
Applications: Auto body and thin sheet brazing in the automotive industry.
The corrosion resistance of zinc-galvanised surfaces remains unaffected.
Little deformation of thin steel sheets.

Mechanical properties of pure welding deposit

(Min. values at room temperature):

Melting range: 965 - 1032 °C
Tensile strength: 350 N/mm²
Yield strength: 120 N/mm²
Elongation (l=5d): 40 %
Thermal elongation: $18.1 \cdot 10^{-6}/K$
Hardness (Brinell): 80 HB
Impact energy (ISO-V): 60 J
Electrical conductivity: 3 - 4 Sm/mm²
Heat conductivity: 35 W/m • K
Specific gravity: 8.5 g/cm³

Welding process: Laser-brazing, laser-hybrid

Shielding gas (DIN EN 439): I 1 (Argon)

Current mode: DC (+pole)

Availability: Diameter (mm): 0.8/1.0/1.2/1.6

Spool type:
B300
S300
S560
Drum

Welding position: according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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