FONTARGEN A 202 M

Copper-silicon wire electrode for MIG-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:

MIG-brazing of zinc or aluminium plated and uncoated steel plates. Applications: Auto body, air condition and container building. The corrosion resistance of zinc plated surfaces remains unaffected . Little deformation of thin steel sheets.

Mechanical properties of pure brazing 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 • 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
Brazing process:	MIG-/MAGM-/Laser-brazing
Shielding gas (DIN EN 439):	I 1 (Argon), M 12 (Ar + 2.5 % CO_2), M 12 (Ar + 1 - 3 % O_2)
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
☒	☒	☒	☐	☒	☒	☐

13/10/JL/1