FONTARGEN A 202 MS



Copper-silicor	wire	electrode	for	laser	brazing
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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):

(min. values at room temperate	10).
Melting range:	965 - 1032 °C
Tensile strength:	350 N/mm ²
Yield strength:	120 N/mm ²
Elongation (I=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/cm ³
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
\boxtimes	\boxtimes	\boxtimes		\boxtimes	\boxtimes	

13/10/JL/1

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