

# SF-Cu

SAFRA  
Si3

## DESCRIPTION

This alloy is used for inert gas arc welding of metals with copper basis, as, for example, copper-silicium, copper-zinc and galvanized sheets, also connected to steel. This material is frequently used for fixing in artistic foundries, for welding galvanized sheets and even as coating of steel using the MIG and TIG methods. It is also suitable for surfaces subject to corrosion.

## AWS A5.7/A5.7M

Er Cu Si-A

## EN ISO 24373

S Cu6560-CuSi3Mn1

## SHIELDING GASES FOR GMAW/GTAW

Argon: I1

Gas flow rate:  
14-18 l/min

## MECHANICAL CHARACTERISTICS

Tensile strenght Rm: 330 - 370 N/mm<sup>2</sup>

Elongation L=5d: 40%

Hardness: 80 - 90 HB

*Mechanical properties quoted above are approximate values, intended for guidance only.*

## CHEMICAL COMPOSITION

in%(m/m)<sup>(a,b)</sup> as per EN ISO 24373

<b>Al</b>	0,02
<b>Si</b>	2,8 - 4,0
<b>Mn</b>	0,5 - 1,5
<b>Sn</b>	0,2
<b>Zn</b>	0,4
<b>Pb</b>	0,02
<b>Fe</b>	0,5
<b>P</b>	0,05
<b>Cu</b>	remainder
	others total 0,5

## AVAILABLE SIZES\*

**MIG: 12,5 Kg – 15 Kg D300 or K300/KS300 spools**

*Diameter of the wire*

0,8 mm - 0,9 mm - 1,0 mm - 1,2 mm - 1,6 mm - 2,0 mm - 2,4 mm

**TIG carton box of 10 kg o Kg 25 (x 1000 mm length)**

*Diameter of the rods*

1,6 mm - 2,0 mm - 2,4 mm - 3,2 mm - 4,0 mm

\* More diameters and packaging upon request

*(a) Single values shown in the table are maximum values, unless otherwise noted.*

*(b) Chemical analysis as per AWS A5.7/A5.7M upon request.*