

OK Autrod CuSi Laser

A solid copper wire intended for laser brazing of zinc coated steel sheets. OK Autrod CuSi Laser is especially developed for laser brazing of body-in-white applications within the automotive industry. Compared to a standard CuSi3Mn1 copper wire OK Autrod CuSi Laser provides a more stable brazing process as well as a superior surface finish.

Classifications Wire Electrode:	SFA/AWS A5.7:ERCuSi-A, EN 14640:S Cu 6560 (CuSi3Mn1)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	130 MPa (19 ksi)	350 MPa (51 ksi)	40 %

Typical Wire Composition %

Mn	Si	Cu	Fe	Sn	Zn
0.9	2.85	96	0.05	0	0.05

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed
1.0 mm (.040 in.)	80-210 A	12.5-18 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (3/64 in.)	150-320 A	16-29 V	5-11.5 m/min (197-453 in./min)