

## GEN C656 Welding Wire and Rod

GEN C656 is used for gas tungsten and gas metal arc welding of copper-silicon and copper-zinc base metals, to themselves and also to steel. It is generally best to keep the weld pool small and the interpass temperature below 150°F (65°C) to minimize hot cracking.

### CONFORMANCES

AWS A5.7	:	ERCuSi-A
ASME SFA-5.7	:	ERCuSi-A
UNS	:	C65600

### AWS CHEMICAL COMPOSITION (TYPICAL)

%Cu	%Sn	%Mn	%Si	%Fe
rem.	1.0 max.	1.5 max.	2.8 – 4.0	0.50 max.
95.9	0.01	0.90	3.1	0.03
%Zn	%Pb	%Al	Total Others	
1.0 max.	0.02 max.	0.01	0.50 max.	
0.02	0.01	0.004		

### TYPICAL WELD METAL MECHANICAL PROPERTIES

Tensile Strength	:	50,000 psi. min.
Elongation	:	65%
Electrical Conductivity	:	7% (of IACS)

### TYPICAL WELDING PARAMETERS\*

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	Electrode	70 – 150	100% Ar
	3/32"	2.4 mm	Negative	150 – 200	100% Ar
	1/8"	3.2 mm	(DCEN)	230 – 390	100% Ar
MIG (GMAW)	.035"	0.9 mm	23 – 26	145 – 185	75% Ar – 25% He
	.045"	1.1 mm	26 – 29	195 – 225	75% Ar – 25% He

\*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<b>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</b> BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.
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