

MIG BRAZING

COATED STEEL FOR THE AUTOMOTIVE INDUSTRY

Why 'Manganese Boron Steel'

In the automotive industry the need to save weight, while at the same time meeting increasingly severe crash test standards, has led to the use of high strength steels that conserve good ductility and formability.

The high yield strength makes this material particularly suited for anti-intrusion functions i.e. fender beams, door reinforcements, middle posts etc.

This sheet steel is pre-aluminised to protect the metal from oxidation and decarburisation, during heat treatment; this also enhances the corrosion resistance after painting, avoiding the need for any subsequent corrosion protection treatment.

MIG Brazing of pre-aluminised (galvanised) sheet

Zinc, in the galvanised coating, melts at temperatures of around 420 C and vaporises at 906 C. This causes unfavourable effects on the welding process as unalloyed SG2 MIG welding wire melts around 1450 C. The zinc starts to vaporise as soon as the arc is struck; zinc vapours and oxides can lead to pores and inadequate fusion. An alternative is to use MIG Braze process, using a copper silicon alloy wire SIFMIG 968 (CuSi3). SIFMIG 968 has a relatively low melting point approx 980 C.

The reduced heat input results in the following advantages:

- Low coating burn off
- No corrosion to the joint seam
- Low distortion



- Dissimilar joints (any combination of material, except aluminium)
- Easy after joint machining
- Fast deposition saving labour costs
- Minimal spatter

Since there is no fusion of the base metal, it therefore has more in common with a brazed joint than a welded one.

The Product - SIFMIG 968

SIFMIG 968 is produced to conform to BS2901 C9 and also Din CuSi3, having a typical composition of 3% Silicon, 1% Manganese and balance Copper. Diameters available: 0.8mm, 1.0mm and 1.2mm

Spool sizes:

- D100 - 0.7kg (in 0.8 and 1.0mm)
- D200 - 4.0kg (50mm bore as 15kg spool)
- D300 - 12.5kg

General Hints

Copper alloy MIG wires require 'soft' or formed wire feed drive rollers and a soft or Teflon type wire liner in the torch cable. If the welding machine has been used with

steel MIG wire, ensure any steel particles are removed from the wire feed system. This is to avoid carbon contamination on the copper alloy wire.

Procedure Tips

On thin sheet steel and galvanised sheet use 0.8mm / 1.0mm SIFMIG 968, keeping heat input to a minimum (approx 45-65 amps).

Select a shielding gas, which will maintain a stable arc, such as pure Argon or Argon 2% CO2 mix.

Pushing MIG torch (as conventional MIG welding) will ensure not too deep penetration, avoiding burn through on thin sheet. If galvanised coating is thick, use dip transfer with a short arc.

For best results, use a programmable synergic MIG machine. This type of system will produce a neat, clean brazed joint, requiring a minimal amount of joint dressing and preparation prior to painting.

sif tips



Technical advice in the original SifTips style was started in 1932. 'Sifbronzing' is an almost universally recognised way of describing the low temperature bronze welding of sheet steel, cast iron and other metals. This explains why Sifbronze, the company which first developed and promoted the technique, is generally considered to be a supplier of high quality welding rods, wires, fluxes and equipment.

'Will the Welder' was a SifTips magazine that was produced in the early 1930s. The aim was to provide users with ideas and tips on how to get the most out of their welding equipment.

Sif is renowned for its UK manufacturing heritage as well as its complete range of quality welding consumables used globally for almost a century.

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