

Key Facts

- Quality silicon bronze filler wire
- Welding of si-br
- Precision layer wound wire
- Easy to use
- High ductility and lower strength

Description

Precision layer wound wire or filler rod used for inert gas arc welding of copper, copper-silicon and copper-zinc base metals to themselves and also to steel.

Premium quality silicon bronze filler rod gives excellent joints on copper to silicon & copper to zinc base metals & to steel. Also used in the hot water & marine industries due to its tensile strength & superior resistance to corrosion. (Cusilman 801).

Classification, Approvals & Conformances

AWS A5.7.ERCuSi-A
UNS C65600

Recommend Shielding Gas

Argon 100%
Helium 75%/Argon 25%

Welding Positions

All positions

Applications

Widely used for fencing, hot water systems, heat exchangers and marine components due to its resistance to corrosion.

- Tig/OXY welding of copper and brass
- Brazing steel
- Automotive panel repairs
- Butt and Fillet welding of galvanised tube and sheet
- Hot water systems
- Marine components

Typical Analysis/Composition

Pb - Lead	Si - Silicon	Cu - Copper	Sn - Tin
< 0.02	2.8 – 4.0	Balance	< 1.0
Mn - Manganese	Al - Aluminum	Others	Zn - Zinc
< 1.5	< 0.01	< 0.05	< 1.0

Typical Weld Mechanical Properties

0.2% Proof Stress	170 MPa
Tensile Strength:	380 MPa
Elongation (in 2 inches):	50%

Packaging & Ordering Information

Size	Weight	Part Number
1.6mm	1kg	300135H
1.6mm	5kg	300135
2.4mm	1kg	300136H
2.4mm	5kg	300136
3.2mm	1kg	300137H
3.2mm	5kg	300137