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	**Ai - 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

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.