SIFTIG C11
Bronze Alloy TIG Rod

SIFPHOSPHORBRONZE No. 8

A phosphor-bronze rod containing 7% tin and suitable for fusion welding of phosphor bronze castings, copper alloys, and brass in TIG and Oxy/Acetylene welding. SIFTIG C11 Bronze Alloy TIG Rod is also used for TIG brazing on ferrous, stainless, and dissimilar metals.

Commonly used on bronze, brass, copper, and copper alloys for applications such as crack repair in castings. The use of flux is normally unnecessary in most applications, but SIFSILCOPPER FLUX - FO070050 can be beneficial in aiding flow when used on copper that is dirty or oxidised.

Weldable in all positions and particularly suitable for welding around pipes (with wall thickness >1.6 mm). Ensure surfaces of the parent metal are cleaned thoroughly before welding.

Positions



For use in all positions.

Current DC=-
Shielding Gas Pure Argon

Typical Weld Metal Composition

Cu Bal Sn 7% P 0.1 - 0.4%

Typical Mechanical Properties

Melting Point	900 - 1050°C
Ultimate Tensile Strength	260N/mm^2
Hardness	80

Available Formats

Dia.	1kg	2.5kg	5kg
1.2mm	RO081201	RO081225	RO081250
1.6mm	RO081601	RO081625	RO081650
2.4mm	RO082401	RO082425	RO082450
3.2mm	RO083201	RO083225	RO083250

Standards

EN ISO 24373 Cu 5180a (CuSn6P)
(BS 2901 C11)