SIFTIG C27
Bronze Brass Alloy TIG Rod

SIFPHOSPHORBRONZE No. 82

A phosphor bronze rod suitable for all welding positions, with 12% tin for improved colour match on brass and lighter bronzes.

The welding material attains high hardness similar to cast bronzes; therefore, it is to be used for special wear-resistant surfacing, joining, and repair welding of bronzes. Particularly suitable for oven soldering.

Where the parent metal contains trace lead (such as in LG2), it is advisable to use SIFTIG C27 Bronze Brass Alloy TIG Rod in the TIG brazing process, and apply in stages, grinding between passes to remove lead drawn into the joint and reduce porosity.

Positions



For use in all positions.

Current DC=-
Shielding Gas Pure Argon

Typical Weld Metal Composition

Cu	Bal	Sn	12%	P	0.2%

Typical Mechanical Properties

Melting Point	825 - 990°C
Ultimate Tensile Strength	320N/mm^2
Hardness	120

Available Formats

Dia.	1kg	2.5kg	5kg
1.6mm	RO821601	RO821625	RO821650
2.4mm	RO822401	RO822425	RO822450
3.2mm			RO823250

Standards

EN ISO 24373: Cu 5410 (CuSn12P)
AWS A5.7: ERCuSn-C
(BS 2901: C27)