# SIFTIG C9
# Copper TIG Rod

## SIFSILCOPPER 968

A copper rod containing 3% silicon and 1% manganese, used for fusion welding materials of similar composition, copper alloys (brass), and for TIG brazing steels. It is also suitable for surfacing steel and dissimilar metal applications. Offers excellent performance on galvanised steel and provides good corrosion resistance.

For use in the shipbuilding/offshore industries, as well as the heating and ventilation industries, for corrosion resistance and tubular product fabrication. It can also be used for sculpture repair.

**When used in Oxy/Acetylene**
SIFSilCopper No. 968 can be used for fusion welding of copper alloys and brass. The Oxy-Acetylene gas flame should be slightly oxidising. Keep the weld puddle small to promote fast solidification and minimise cracking. SIFSILCOPPER FLUX - FO070050 should be used both before and during welding. Pre-heating is not recommended.

### Positions



For use in all positions.

**Current** DC=-
**Shielding Gas** Pure Argon

### Typical Weld Metal Composition

Mn 1% Si 3% Cu Bal

### Typical Mechanical Properties

| | |
|---|---|
| Melting Point | 980 - 1020°C |
| Ultimate Tensile Strength | 350N/mm$^2$ |
| Hardness | 90 |

### Available Formats

| Dia. | 1kg | 2.5kg | 5kg |
|---|---|---|---|
| **1.2mm** | RO961201 | RO961225 | RO961250 |
| **1.6mm** | RO961601 | RO961625 | RO961650 |
| **2.4mm** | RO962401 | RO962425 | RO962450 |
| **3.2mm** | RO963201 | RO963225 | RO963250 |

### Standards

EN ISO 24373 Cu6560 (CuSi3Mn1)
(BS 2901 C9)