SIFMIG C11
Phosphor Bronze Alloy Wire

SIFMIG No. 8

A phosphor bronze wire containing 7% tin, suitable for fusion welding of phosphor bronze castings, copper alloys, and brass. It is also used for MIG brazing on ferrous, stainless, and dissimilar metals, or for applying a bearing surface.

This wire is popularly used on bronze, brass, copper, and copper alloys for applications such as crack repair in castings and for providing a wear-resistant layer on surfaces subject to abrasion.

Where the parent metal contains trace lead (such as LG2), it is advisable to apply SIFMIG C11 Phosphor Bronze Alloy Wire in stages, grinding between passes to remove lead drawn into the joint and to reduce porosity. Ensure that the surfaces of the parent metal are thoroughly cleaned before welding.

Positions



For use in all positions, and particularly useful in hard to reach areas.

Current DC=+
Shielding Gas Pure Argon or 95/5 $ArCO_2$ (5% CO_2)

Available Formats

Dia.	12.5kg
0.8mm	WO080812
1.0mm	WO081012
1.2mm	WO081212

Typical Weld Metal Composition

Sn 7%	Cu Bal

Typical Mechanical Properties

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

Standards

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